

## DESCRIPTION

Executive 1100 is a 99% pure aluminum welding alloy that is designed to be softer and highly formable.

The high degree of formability makes Executive 1100 an excellent choice for thin gauge, architectural and decorative applications.

Adding to the appeal for decorative and architectural appeal is the extremely clean final bead appearance and the slightly golden color after anodizing.

## APPLICATIONS & FEATURES

Executive 1100 exhibits good wetting characteristics and is suitable as filler alloy. Anodizing provides bright finishes. Used for heat exchangers, food handling equipment, rivets, tie wire and metalizing.

## TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

Al	Mn	Fe + Si	Cu	Be	Mg	Zn	TOE
99.0	0.50	0.95	0.05-0.20	0.0003	0.50	0.10	0.05-0.15
<b>Tensile Strength:</b>		14,000 PSI min	<b>Elongation:</b>		5%		
<b>Yield Strength:</b>		8,000 PSI min					

## TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
<b>GMAW</b>	.035"	23-25	90-170		
	.047"	25-27	110-220	30 to 50 CFH	100% Ar
	.062"	26-30	200-300		
<b>GTAW</b>	.093" .125"	Direct Current; Electrode -		20 to 30 CFH	100% Ar

## STANDARD PACKAGING

<b>GMAW (MIG)</b>	16-lb / 20-lb spools 1-lb plastic spools	1,536-lb / 1,920-lb pallet 20-lb box	300-lb / 500-lb drums
<b>GTAW (TIG)</b>	10-lb tube	50-lb box	

## CLASSIFICATION

AWS/SFA 5.10, Class **ER1100**  
Certified by the Canadian Welding Bureau (CWB) to AWS A5.10.

