

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
Tensile Strength:		14,000 PSI min	Elongation:		5%		
Yield Strength:		8,000 PSI min					

TYPICAL WELDING PARAMETERS

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

STANDARD PACKAGING

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

CLASSIFICATION

AWS/SFA 5.10, Class **ER1100**

