# Alloy: COREWELD 1100 | Class: ER1100

ER1100 • Weld Process: MIG & TIG

CERTIFIED TO
**AWS A5.10**
**ASME SFA A5.10**

## AWS CHEMICAL COMPOSITION REQUIREMENTS | DEPOSITED CHEMICAL COMPOSITION % (TYPICAL)

| AWS REQUIREMENT (%) | |
|---|---|
| **Si & Fe** | 0.95 max |
| **Zn** | 0.10 max |
| **Cu** | 0.05 – 0.20 |
| **Al** | 99.00 |
| **Mn** | 0.05 max |
| **Be** | 0.0003 |
| **Other** | 0.05 each – 0.15 max total |

Deposited chemistry is influenced by many factors, so no typical analysis can be reported.

## DEPOSITED ALL WELD METAL PROPERTIES % (AS-WELDED) | CHARPY-V-NOTCH IMPACT PROPERTIES %

Deposited all weld metal properties are influenced by many factors such as weld process used, so no typical weld metal properties can be reported.

| CHARPY-V-NOTCH IMPACT |
|---|
| *Not applicable* |

## RECOMMENDED OPERATION OF WELDING RODS

| EXAMPLE | GMAW (MIG) | GTAW (TIG) |
|---|---|---|
| **Diameter** | .030 | All diameters (AC) or DCEP for thin gauge |
| **Amps (DC)** | 120–150 (DCEP) | |
| **Volts** | 20–24 | |
| **Gas** | Argon 30 CFH | Argon or Argon + Helium for thick base metal |
| **Travel Speed** | 24–30 IPM | |

## APPLICATION

COREWELD 1100 (Type ER1100) can be used to weld base materials types 1060, 1070, 1080, and 3003.

– The proper choice of aluminum filler metal mainly depends on the base metal properties to be achieved and welding technique. Post weld cracking, corrosion resistance and behavior under elevated temperature also need to be taken into consideration.

– Cracking usually can be minimized by choosing a filler metal alloy of higher alloy content than the base metal.

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