



PRODUCT DATA SHEET

Nexalloy 1100 is 99% aluminum filler typically used on similar base metal such as 1060,1070, 1080, 1100, 1350 and 3003.

NEXAL WELDING PRODUCTS APPROVALS AND SPECIFICATIONS:

AWS A5.10 classification ER1100, R1100

Chemical Composition (weight %):

Aluminum	99.0 Min
Manganese	0.50 maximum
Iron +Silicon	0.95 maximum
Copper	0.05-0.20
Zinc	0.10 maximum
Beryllium	0.0008 maximum
Others elements	each 0.05 maximum & total 0.15 maximum

Typical Properties:

Melting range	1090°– 1215°F 643°-657°C
Tensile Strength psi	14-23,000
Yield Strength psi	8-22,500
Elongation in 2"	5-32%
Density	.098 lbs\cu in
Post Anodize Color	white-gold

Wire and Rod Diameters available:

.030, .035, 3/64", 1/16", 3/32", 1/8", 5/32", 3/16", 1/4", 5/16"

Packaging available:

Plastic Spools of 1lb, 5lb, 10lb, 16lb, 20lb
Tig rods of 5lb, 10lb, 50lb

Metal Spool of 10lb, 15lb,
Drums of 150lb & 300lb

MIG WELDING PROCEDURES; DCEP

Wire Diameter	WFS ipm	Amps	Volts	Consumption lb/100 ft	Argon (cfh)
0.030	480-625	60-175	15-24	0.65-1.25	25-30
0.035	450-750	70-185	15-27	1.0-4.25	30-35
3/64	330-500	125-260	20-29	1.0-4.25	35-45
1/16	250-450	170-300	24-30	3.8-66	45-75
3/32	160-200	275-400	26-31	35-66	60-85

TIG WELDING PROCEDURES; ACHF with Pure or Ziconiated Hemisphere shape tungsten tip

Base thickness	Filler Wire Size	Tungsten	Amps	Consumption lb/100 ft	Gas Cup Size	Argon (cfh)
1/16"	1/16"	1/16"	60-80	.75	3/8"	20
3/32"	3/32"	3/32"	85-120	1.0	3/8"	20
1/8"	3/32"	3/32"	125-160	1.5	3/8"	20
3/16"	1/8"	1/8"	190-220	4.5-6	7/16"	25
1/4"	5/32"	5/32"	200-300	8-10	1/2"	30
3/8"	3/16"	3/16"	330-380	15-20	5/8"	35
1/2"	1/4"	1/4"	400-450	25-40	5/8"	40

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American Welding Society

Sustaining Company Member

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