



## 2 알루미늄 와이어

알루미늄 합금

WELDING CONSUMABLES GUIDE BOOK



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알루미늄 와이어

# 알루미늄 합금용

## MIG용 와이어, TIG용 와이어

BaseAlloys	Characteristics Filler Alloys	1070, 1080 1060, 1350	1100	2014, 2036	2219	3003 ALCLAD 3003	3004	ALCLAD 3004	5005, 5050	5052, 5552
		WSDCTM	WSDCTM	WSDCTM	WSDCTM	WSDCTM	WSDCTM	WSDCTM	WSDCTM	WSDCTM
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에어록미늄  
영문로 표기함



# 알루미늄 합금용

## TIG용 와이어

품 명		AWS규격	주요화합성분(%)								
			Si	Fe	Cu	Mn	Mg	Ti	기타	Al	
Alloy	1100	ER1100 해당	Si+Fe : ≤0.95	0.05~0.20	≤0.05	-	-			≥99.0	
	2319	ER2319 해당	≤0.20	≤0.30	5.8~6.8	0.20~0.40	≤0.02	0.10~0.20			
	4043	ER4043 해당	4.5~6.0		≤0.30	≤0.05	≤0.05	≤0.20			
	4047	ER4047 해당	11.0~13.0	≤0.80		≤0.15	≤0.10	-			
	4643	ER4643 해당	3.6~4.6			≤0.05	0.10~0.30	≤0.15			
	5180	ER5180 해당	Si+Fe : ≤0.35		0.20~0.70	3.5~4.5	0.06~0.20				
	5183	ER5183 해당	≤0.40		≤0.10	0.50~1.0	4.3~5.2	≤0.15			
	5356	ER5356 해당		0.05~0.20		4.5~5.5	0.06~0.20				
	5554	ER5554 해당	≤0.25	≤0.40		0.50~1.0	2.4~3.0	0.05~0.20			
	5556	ER5556 해당			4.7~5.5						
	5654	ER5654 해당	Si+Fe : ≤0.45	≤0.05	≤0.01	3.1~3.9	0.05~0.15				
	R-206.0	-	≤0.10	≤0.15	4.2~5.0	0.20~0.50	0.15~0.35	0.15~0.30			
	R-A356.0	ER4010 해당		≤0.20	≤0.20	≤0.10	0.25~0.45	≤0.20			
		ER4008 해당	6.5~7.5	≤0.09	≤0.05	≤0.05	0.35~0.45	0.04~0.15			
	R-357.0	-		≤0.15		≤0.03	0.45~0.6				
	R-C355.0	ER4009 해당	4.5~5.5	≤0.20	1.0~1.5	≤0.10	0.40~0.6	≤0.20			

- 사용실드가스 : Ar
- 봉      경 :  $\varnothing 1.2 \sim 4.8 \text{mm}$

## 알루미늄 합금의 구분

