

DESCRIPTION

The alloy AlCu6MnZrTi/2319 is heat treatable and produces higher strength and ductility than the 4xxx series filler alloys when welds in 2014, 2036, 2219 and Al-Cu casting alloys are post welds heat-treated.

AWS A5.10/A5.10M

ER2319,R2319

EN ISO 18273

S Al 2319 / AlCu6MnZrTi

MATERIALS TO BE WELDED

2014 - 2219

SHIELDING GASES FOR GMAW/GTAW

I1, I2, I3

MINIMAL VALUES OF THE MECHANICAL PROPERTIES *(welded metal)*

Tensile strenght Rm:	140 N/mm ²
Yeld strenght Rp 0,2:	70 N/mm ²
Elongation L=5d:	12 %

AVAILABLE SIZES*

MIG: 5-6-7 Kg D300 or K300/KS300 spools

Diameter of the wire

0,8 mm - 0,9 mm - 1,0 mm - 1,2 mm - 1,6 mm - 2,0 mm - 2,4 mm

TIG carton box of 10 Kg (x 1000 mm length)

Diameter of the rods

1,6 mm - 2,0 mm - 2,4 mm - 3,2 mm - 4,0 mm - 5,0 mm

MINI-MIG: 0,5 Kg D100 spools / 2 Kg D200 spools

Diameter of the wire

0,8 mm - 0,9 mm - 1,0 mm - 1,2 mm - 1,6 mm

* More diameters and packaging upon request

CHEMICAL COMPOSITION

in% (m/m)^(a)

Al	remainder
Zr	0,10-0,25
Si	0,20
Fe	0,30
Cu	5,8 - 6,8
Mn	0,20 - 0,40
Mg	0,02
Zn	0,10
Ti	0,10 - 0,20
Be	0,0003
V	0,05 - 0,15
	others each 0,05
	others total 0,15

(a) Single values shown in the table are maximum values, unless otherwise noted.