



Changzhou Sanzhong Welding Materials Co.,Ltd

www.asweld.com

Standard AWS A5.10 ER2319	Chemical Composition %										
	Si	Fe	Cu	Mn	Zn	Mg	Zr	Ti	AL	Other Each	Other Total
Grade ER2319	≤0.2	≤0.3	5.8~ 6.8	0.2~0.4	≤ 0.1	≤ 0.02	0.1~0.2 5	0.1~ 0.2	Rest	≤ 0.05	≤ 0.15
Type	Spool (MIG)						Tube (TIG)				
Specification (MM)	0.8、 0.9、 1.0、 1.2、 1.6、 2.0						1.6、 2.0、 2.4、 3.2、 4.0、 5.0				
Package	S100/0.5kg S270,S300/6kg-7kg				S200/2kg S360/20kg		5kg/box	10kg/box	length :1000MM		
Mechanical Properties	Fusion Temperature ℃		Electrical IACS		Density g/mm3		Tensile Mpa		Yield Mpa		Elongation %
	543 – 643		29%		2.64		290 – 340		170 – 220		8 – 14
	Diameter (MM)		1.2			1.6			2.0		
MIG Welding	Welding Current - A		180 – 300			200 – 400			240 – 450		
	Welding Voltage- V		18 – 28			20 – 24			22 – 34		
TIG Welding	Diameter (MM)		1.6 – 2.4			2.4 – 4.0			4.0 – 5.0		
	Welding Current - A		150 – 250			200 – 320			220 – 400		
Performance characteristics	AWS A5.10 ER2319 (AlCu6MnZrTi) is a heat-treatable aluminum-copper solid welding wire with manganese, zirconium and titanium as grain refiners. Its weld metal shows tensile strength of 290 – 340 MPa in as-welded condition and can reach 380 – 420 MPa after T6 post-weld heat treatment. It is designed for welding 2219 high-strength aluminum alloy widely used in aerospace and new energy structural parts.										
Application	AWS A5.10 ER2319 solid aluminium wire (AlCu6MnZrTi) contains Cu, Mn, Zr and Ti; its weld metal can achieve 290 – 340 MPa as-welded tensile strength and up to 380 – 420 MPa after T6 heat treatment for welding 2219 high strength aluminium alloy.										
Notice	1、 The product can be kept for two years under the condition of factory packing and sealed, and the packing can be removed for three months under the usual atmospheric environment. 2、 Products should be stored in a ventilated, dry and place. 3、 After the wire is removed from the package, it is recommended that appropriate dust proof cover be applied over the wire.										



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