

---

---

**Welding consumables — Wire  
electrodes, wires and rods for welding  
of aluminium and aluminium alloys —  
Classification**

*Produits consommables pour le soudage — Fils-électrodes, fils et  
baguettes pour le soudage de l'aluminium et les alliages d'aluminium  
— Classification*

STANDARDSISO.COM : Click to view the full PDF of ISO 18273:2015



STANDARDSISO.COM : Click to view the full PDF of ISO 18273:2015



**COPYRIGHT PROTECTED DOCUMENT**

© ISO 2015, Published in Switzerland

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office  
Ch. de Blandonnet 8 • CP 401  
CH-1214 Vernier, Geneva, Switzerland  
Tel. +41 22 749 01 11  
Fax +41 22 749 09 47  
copyright@iso.org  
www.iso.org

# Contents

|  | Page     |
|--|----------|
| Foreword .....   | iv       |
| Introduction .....                                     | v        |
| <b>1 Scope .....</b>                                   | <b>1</b> |
| <b>2 Normative references .....</b>                    | <b>1</b> |
| <b>3 Classification .....</b>                          | <b>1</b> |
| <b>4 Symbols and requirements .....</b>                | <b>5</b> |
| 4.1 Symbols for the product form .....                 | 5        |
| 4.2 Symbol for the chemical composition .....          | 5        |
| <b>5 Mechanical properties of the weld metal .....</b> | <b>5</b> |
| <b>6 Chemical analysis .....</b>                       | <b>5</b> |
| <b>7 Rounding procedure .....</b>                      | <b>5</b> |
| <b>8 Retest .....</b>                                  | <b>5</b> |
| <b>9 Technical delivery conditions .....</b>           | <b>6</b> |
| <b>10 Designation .....</b>                            | <b>6</b> |

STANDARDSISO.COM : Click to view the full PDF of ISO 18273:2015

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*.

This second edition cancels and replaces the first edition (ISO 18273:2004), which has been technically revised.

Requests for official interpretations of any aspect of this International Standard should be directed to the Secretariat of ISO/TC 44/SC 3, through your national standards body, a complete listing of which can be found at [www.iso.org](http://www.iso.org).

## Introduction

For aluminium welding consumables, there is no unique relationship between the product form (solid wire or rod) and the welding process used (e.g. gas shielded metal arc welding, gas tungsten arc welding, plasma arc welding, or other welding processes). For this reason, the solid wires or rods can be classified on the basis of any of the above product forms and can be used as appropriate for more than one of the above processes.

STANDARDSISO.COM : Click to view the full PDF of ISO 18273:2015

[STANDARDSISO.COM](https://standardsiso.com) : Click to view the full PDF of ISO 18273:2015

# Welding consumables — Wire electrodes, wires and rods for welding of aluminium and aluminium alloys — Classification

## 1 Scope

This International Standard specifies requirements for classification of solid wires and rods for fusion welding of aluminium and aluminium alloys. The classification of the solid wires and rods is based on their chemical composition.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 544, *Welding consumables — Technical delivery conditions for filler materials and fluxes — Type of product, dimensions, tolerances and markings*

ISO 14344, *Welding consumables — Procurement of filler materials and fluxes*

ISO 80000-1:2009, *Quantities and units — Part 1: General*. Corrected by ISO 80000-1:2009/Cor 1:2011

## 3 Classification

The classification is divided into two parts.

- a) The first part indicates the product form being solid wires or rods (see [4.1](#)).
- b) The second part gives a numerical symbol indicating the chemical composition of the solid wire or rod (see [Table 1](#)).

The aluminium or aluminium alloy chemical composition limits specified are strictly identical to those registered to the Aluminium Association, Washington, DC 20006, U.S.A. for the corresponding alloys.

Table 1 — Symbol for the chemical composition of solid wires and rods

| Alloy symbol          |              | Chemical composition in % (m/m) <sup>a</sup> |              |            |              |              |      |      |                   |              |              |           |              |            |             |
|-----------------------|--------------|--|--------------|------------|--------------|--------------|------|------|-------------------|--------------|--------------|-----------|--------------|------------|-------------|
| Numerical             | Chemical     | Si   | Fe           | Cu         | Mn           | Mg           | Cr   | Zn   | Ga, V             | Ti           | Zr           | Al (min.) | Be           | Other each | Other total |
| ALUMINIUM-LOW ALLOYED |              |  |              |            |              |              |      |      |                   |              |              |           |              |            |             |
| Al 1070               | Al99,7       | 0,20   | 0,25         | 0,04       | 0,03         | 0,03         | -    | 0,04 | V 0,05            | 0,03         | -            | 99,70     | 0,000 3      | 0,03       | -           |
| Al 1080A              | Al99,8(A)    | 0,15   | 0,15         | 0,03       | 0,02         | 0,02         | -    | 0,06 | Ga 0,03           | 0,02         | -            | 99,80     | 0,000 3      | 0,02       | -           |
| Al 1188               | Al99,88      | 0,06   | 0,06         | 0,005      | 0,01         | 0,01         | -    | 0,03 | Ga 0,03<br>V 0,05 | 0,01         | -            | 99,88     | 0,000 3      | 0,01       | -           |
| Al 1100               | Al99,0Cu     | Si + Fe 0,95                                 | 0,05 to 0,20 | 0,05       | 0,05         | -            | -    | 0,10 | -                 | -            | -            | 99,00     | 0,000 3      | 0,05       | 0,15        |
| Al 1200               | Al99,0       | Si + Fe 1,00                                 | 0,05         | 0,05       | 0,05         | -            | -    | 0,10 | -                 | 0,05         | -            | 99,00     | 0,000 3      | 0,05       | 0,15        |
| Al 1450               | Al99,5Ti     | 0,25   | 0,40         | 0,05       | 0,05         | 0,05         | -    | 0,07 | -                 | 0,10 to 0,20 | -            | 99,50     | 0,000 3      | 0,03       | -           |
| ALUMINIUM-COPPER      |              |  |              |            |              |              |      |      |                   |              |              |           |              |            |             |
| Al 2319               | AlCu6MnZrTi  | 0,20   | 0,30         | 5,8 to 6,8 | 0,20 to 0,40 | 0,02         | -    | 0,10 | V 0,05 to 0,15    | 0,10 to 0,20 | 0,10 to 0,25 | Rem       | 0,0003       | 0,05       | 0,15        |
| ALUMINIUM-MANGANESE   |              |  |              |            |              |              |      |      |                   |              |              |           |              |            |             |
| Al 3103               | AlMn1        | 0,50   | 0,7          | 0,10       | 0,9 to 1,5   | 0,30         | 0,10 | 0,20 | -                 | Ti + Zr 0,10 | -            | Rem       | 0,0003       | 0,05       | 0,15        |
| ALUMINIUM-SILICIUM    |              |  |              |            |              |              |      |      |                   |              |              |           |              |            |             |
| Al 4009               | AlSi5Cu1Mg   | 4,5 to 5,5                                   | 0,20         | 1,0 to 1,5 | 0,10         | 0,45 to 0,6  | -    | 0,10 | -                 | 0,20         | -            | Rem       | 0,000 3      | 0,05       | 0,15        |
| Al 4010               | AlSi7Mg      | 6,5 to 7,5                                   | 0,20         | 0,20       | 0,10         | 0,30 to 0,45 | -    | 0,10 | -                 | 0,20         | -            | Rem       | 0,000 3      | 0,05       | 0,15        |
| Al 4011               | AlSi7Mg0,5Ti | 6,5 to 7,5                                   | 0,20         | 0,20       | 0,10         | 0,45 to 0,7  | -    | 0,10 | -                 | 0,04 to 0,20 | -            | Rem       | 0,04 to 0,07 | 0,05       | 0,15        |
| Al 4018               | AlSi7Mg      | 6,5 to 7,5                                   | 0,20         | 0,05       | 0,10         | 0,50 to 0,8  | -    | 0,10 | -                 | 0,20         | -            | Rem       | 0,000 3      | 0,05       | 0,15        |
| Al 4020 <sup>d</sup>  | AlSi3Mn1     | 2,5 to 3,5                                   | 0,20         | 0,03       | 0,8 to 1,2   | 0,01         | 0,01 | -    | -                 | 0,005        | 0,01         | Rem       | 0,000 3      | 0,02       | 0,10        |
| Al 4043               | AlSi5        | 4,5 to 6,0                                   | 0,8          | 0,30       | 0,05         | 0,05         | -    | 0,10 | -                 | 0,20         | -            | Rem       | 0,000 3      | 0,05       | 0,15        |

<sup>a</sup> Single values shown in the table are maximum values except for Al which are minimum values.  
<sup>b</sup> For Alloy Al 5754, the sum (Mn + Cr): 0,10 to 0,6.  
<sup>c</sup> Consumables for which the chemical composition is not listed in this table shall be symbolized similarly and prefixed by the letter Z. The chemical composition ranges are not specified and therefore it is possible that two electrodes with the same Z classification are not interchangeable.  
<sup>d</sup> For Alloy Al 4020, B (Max.) = 0,005 %.

Table 1 (continued)

| Alloy symbol        |              | Chemical composition in % (m/m) <sup>a</sup> |      |            |              |              |              |      |       |              |              |           |         |            |             |
|---------------------|--------------|--|------|------------|--------------|--------------|--------------|------|-------|--------------|--------------|-----------|---------|------------|-------------|
| Numerical           | Chemical     | Si   | Fe   | Cu         | Mn           | Mg           | Cr           | Zn   | Ga, V | Ti           | Zr           | Al (min.) | Be      | Other each | Other total |
| Al 4043A            | AlSi5(A)     | 4,5 to 6,0                                   | 0,6  | 0,30       | 0,15         | 0,20         | -            | 0,10 | -     | 0,15         | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 4046             | AlSi10Mg     | 9,0 to 11,0                                  | 0,50 | 0,03       | 0,40         | 0,20 to 0,50 | -            | 0,10 | -     | 0,15         | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 4047             | AlSi12       | 11,0 to 13,0                                 | 0,8  | 0,30       | 0,15         | 0,10         | -            | 0,20 | -     | -            | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 4047A            | AlSi12(A)    | 11,0 to 13,0                                 | 0,6  | 0,30       | 0,15         | 0,10         | -            | 0,20 | -     | 0,15         | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 4145             | AlSi10Cu4    | 9,3 to 10,7                                  | 0,8  | 3,3 to 4,7 | 0,15         | 0,15         | 0,15         | 0,20 | -     | -            | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 4643             | AlSi4Mg      | 3,6 to 4,6                                   | 0,8  | 0,10       | 0,05         | 0,10 to 0,30 | -            | 0,10 | -     | 0,15         | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 4943             | AlSi5Mg      | 5,0 to 6,0                                   | 0,40 | 0,10       | 0,05         | 0,10 to 0,50 | -            | 0,10 | -     | 0,15         | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| ALUMINIUM-MAGNESIUM |              |  |      |            |              |              |              |      |       |              |              |           |         |            |             |
| Al 5249             | AlMg2Mn0,8Zr | 0,25   | 0,40 | 0,05       | 0,50 to 1,1  | 1,6 to 2,5   | 0,30         | 0,20 | -     | 0,15         | 0,10 to 0,20 | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 5554             | AlMg2,7Mn    | 0,25   | 0,40 | 0,10       | 0,50 to 1,0  | 2,4 to 3,0   | 0,05 to 0,20 | 0,25 | -     | 0,05 to 0,20 | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 5654             | AlMg3,5Ti(A) | Si + Fe 0,45                                 | 0,45 | 0,05       | 0,01         | 3,1 to 3,9   | 0,15 to 0,35 | 0,20 | -     | 0,05 to 0,15 | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 5654A            | AlMg3,5Ti    | Si + Fe 0,45                                 | 0,45 | 0,05       | 0,01         | 3,1 to 3,9   | 0,15 to 0,35 | 0,20 | -     | 0,05 to 0,15 | -            | Rem       | 0,000 5 | 0,05       | 0,15        |
| Al 5754b            | AlMg3        | 0,40   | 0,40 | 0,10       | 0,50         | 2,6 to 3,6   | 0,30         | 0,20 | -     | 0,15         | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 5356             | AlMg5Cr(A)   | 0,25   | 0,40 | 0,10       | 0,05 to 0,20 | 4,5 to 5,5   | 0,05 to 0,20 | 0,10 | -     | 0,06 to 0,20 | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 5356A            | AlMg5Cr      | 0,25   | 0,40 | 0,10       | 0,05 to 0,20 | 4,5 to 5,5   | 0,05 to 0,20 | 0,10 | -     | 0,06 to 0,20 | -            | Rem       | 0,000 5 | 0,05       | 0,15        |

<sup>a</sup> Single values shown in the table are maximum values except for Al which are minimum values.

<sup>b</sup> For Alloy Al 5754, the sum (Mn + Cr): 0,10 to 0,6.

<sup>c</sup> Consumables for which the chemical composition is not listed in this table shall be symbolized similarly and prefixed by the letter Z. The chemical composition ranges are not specified and therefore it is possible that two electrodes with the same Z classification are not interchangeable.

<sup>d</sup> For Alloy Al 4020, B (Max.) = 0,005 %.

Table 1 (continued)

| Alloy symbol  |                 | Chemical composition in % (m/m) <sup>a</sup> |      |      |             |            |              |      |       |              |              |           |         |            |             |
|---|-----------------|--|------|------|-------------|------------|--------------|------|-------|--------------|--------------|-----------|---------|------------|-------------|
| Numerical   | Chemical        | Si   | Fe   | Cu   | Mn          | Mg         | Cr           | Zn   | Ga, V | Ti           | Zr           | Al (min.) | Be      | Other each | Other total |
| Al 5556   | AlMg5MnTi(A)    | 0,25   | 0,40 | 0,10 | 0,50 to 1,0 | 4,7 to 5,5 | 0,05 to 0,20 | 0,25 | -     | 0,05 to 0,20 | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 5556C  | AlMg5MnTi       | 0,25   | 0,40 | 0,10 | 0,50 to 1,0 | 4,7 to 5,5 | 0,05 to 0,20 | 0,25 | -     | 0,05 to 0,20 | -            | Rem       | 0,000 5 | 0,05       | 0,15        |
| Al 5556A  | AlMg5Mn1(A)     | 0,25   | 0,40 | 0,10 | 0,6 to 1,0  | 5,0 to 5,5 | 0,05 to 0,20 | 0,20 | -     | 0,05 to 0,20 | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 5556B  | AlMg5Mn1        | 0,25   | 0,40 | 0,10 | 0,6 to 1,0  | 5,0 to 5,5 | 0,05 to 0,20 | 0,20 | -     | 0,05 to 0,20 | -            | Rem       | 0,000 5 | 0,05       | 0,15        |
| Al 5183   | AlMg4,5Mn0,7(A) | 0,40   | 0,40 | 0,10 | 0,50 to 1,0 | 4,3 to 5,2 | 0,05 to 0,25 | 0,25 | -     | 0,15         | -            | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 5183A  | AlMg4,5Mn0,7    | 0,40   | 0,40 | 0,10 | 0,50 to 1,0 | 4,3 to 5,2 | 0,05 to 0,25 | 0,25 | -     | 0,15         | -            | Rem       | 0,000 5 | 0,05       | 0,15        |
| Al 5087   | AlMg4,5MnZr(A)  | 0,25   | 0,40 | 0,05 | 0,7 to 1,1  | 4,5 to 5,2 | 0,05 to 0,25 | 0,25 | -     | 0,15         | 0,10 to 0,20 | Rem       | 0,000 3 | 0,05       | 0,15        |
| Al 5187   | AlMg4,5MnZr     | 0,25   | 0,40 | 0,05 | 0,7 to 1,1  | 4,5 to 5,2 | 0,05 to 0,25 | 0,25 | -     | 0,15         | 0,10 to 0,20 | Rem       | 0,000 5 | 0,05       | 0,15        |
| Z <sup>c</sup>  |                 | Any other agreed composition                 |      |      |             |            |              |      |       |              |              |           |         |            |             |
| <p><sup>a</sup> Single values shown in the table are maximum values except for Al which are minimum values.</p> <p><sup>b</sup> For Alloy Al 5754, the sum (Mn + Cr): 0,10 to 0,6.</p> <p><sup>c</sup> Consumables for which the chemical composition is not listed in this table shall be symbolized similarly and prefixed by the letter Z. The chemical composition ranges are not specified and therefore it is possible that two electrodes with the same Z classification are not interchangeable.</p> <p><sup>d</sup> For Alloy Al 4020, B (Max.) = 0,005 %.</p> |                 |  |      |      |             |            |              |      |       |              |              |           |         |            |             |

## 4 Symbols and requirements

### 4.1 Symbols for the product form

The symbol for the solid wire and rod shall be S.

NOTE One product form can be used for more than one welding process.

### 4.2 Symbol for the chemical composition

The numerical symbol in [Table 1](#) indicates the chemical composition of a solid wire and rod determined under the conditions given in [Clause 6](#).

NOTE In addition, the chemical symbol can be used.

## 5 Mechanical properties of the weld metal

Mechanical properties of the weld metal are not part of the classification.

## 6 Chemical analysis

Chemical analysis shall be performed on samples of the product or the stock from which it is made. Any analytical technique can be used, but in case of dispute, reference shall be made to established published methods.

## 7 Rounding procedure

For the purposes of determining compliance with the requirements of this International Standard, the actual test values obtained shall be subject to ISO 80000-1:2009, B.3, Rule A. If the measured values are obtained by the equipment calibrated in units other than those of this International Standard, the measured values shall be converted to the units of this International Standard before rounding. If an arithmetic average value is to be compared to the requirements of this International Standard, rounding shall be done only after calculating the arithmetic average. If a test method cited in [Clause 2](#) contains instructions for rounding that conflict with the instructions of this International Standard, the rounding requirements of the test method standard shall apply. The rounded results shall fulfil the requirements of the appropriate table for the classification under test.

## 8 Retest

If any test fails to meet the requirement, that test shall be repeated twice. The results of both retests shall meet the requirement. Specimens for the retest may be taken from the original test sample or from a new test sample. For chemical analysis, retest need be only for those specific elements that failed to meet their test requirement. If the results of one or both retests fail to meet the requirement, the material under test shall be considered as not meeting the requirements of this specification for that classification.

In the event that, during preparation or after completion of any test, it is clearly determined that prescribed or proper procedures were not followed in preparing the weld test sample or test specimen(s), or in conducting the tests, the test shall be considered invalid, without regard to whether the test was actually completed, or whether the test results met, or failed to meet, the requirement. That test shall be repeated, following proper prescribed procedures. In this case, the requirement for doubling the number of test specimens does not apply.