

铝焊丝选材对照表 / Aluminum Filler Alloy Chart

Base Alloy 母材	Filler 焊丝	1060, 1070 1080, 1350	1100	2014 2036	2219	3003 ALCLAD3003	3004
Characteristics 特性		S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M
319.0, 333.0 354.0, 355.0 C355.0, 380.0	2319			B A A A A A	B A A A A A		
	4043	B A A A A A	B A A A A A	C C B C A A	C C B C A A	B B A A A A	B B A A A A
	4145	A A B A A A	A A B A A A	A B C B A A	A B C B A A	A A B A A A	A A B A A A
413.0, 443.0 444.0, 356.0 A356.0, 359.0 A357.0	4043	A A A A A A	A A A A A A	B B A A A A	B B A A A A	A A A A A A	A A A A A A
	4145	A A B B A	A A B B A	A A B A A	A A B A A	A A B B A	
7005, 7021 7039, 7046 7146, 710.0 711.0	4043	A A C A A	A A C A A	B B A A A A	B B A A A A	A B C A A	A D C B A
	4145			A A B A A A	A A B A A A		
	5183	B A B A A	B A B A A			B A B A A	B A B A A
	5356	B A A A A	B A A A A			B A A A A	B B A A A
	5554						C C A A A A
	5556	B A B A A	B A B A A			B A B A A	B A B A A
	5654						C C A A B
6061 6070	4043	A A C A A	A A C A A	B B A A A A	B B A A A A	A B C A A	A D C A A
	4145	A A D B A	A A D B A	A A B A A A	A A B A A A	A A D B A	B C D B A
	5183	B A B A A	B A B A A			B A B A A	B A B A A
	5356	B A A A A	B A A A A			B A A A A	B B A A A
	5556	B A B A A	B A B A A			B A B A A	B A B A A
6005, 6063 6101, 6151 6201, 6351 6951	4043	A A C A A	A A C A A	B B A A A A	B B A A A A	A B C A A	A D C A A
	4145	A A D B A	A A D B A	A A B A A A	A A B A A A	A A D B A	B C D B A
	5183	B A B A A	B A B A A			B A B A A	B A B A A
	5356	B A A A A	B A A A A			B A A A A	B B A A A
	5556	B A B A A	B A B A A			B A B A A	B A B A A
5454	4043	A B C C A	A B C C A			A B C C A	A D C C A
	5183	B A B B A	B A B B A			B A B B A	B A B B A
	5356	B A A B A	B A A B A			B A A B A	B B A B A
	5554	C A A A A A	C A A A A A			C A A A A A	C C A A A A
	5556	B A B B A	B A B B A			B A B B A	B A B B A
511.0, 512.0 513.0, 514.0 5154, 5254 535.0	4043	A B C C	A B C C			A B C C	A D C C
	5183	B A B B A	B A B B A			B A B B A	B A B B A
	5356	B A A B A	B A A B A			B A A B A	B B A B A
	5554	C A A A A	C A A A A			C A A A A	C C A A A
	5556	B A B B A	B A B B A			B A B B A	B A B B A
	5654	C A A A B	C A A A B			C A A A B	C C A A B

Base Alloy 母材	Filler 焊丝	ALCLAD 3004	5005 5050	5052 5652	5083 5456	5086 5056	511.0, 512.0 513.0, 514.0 5154, 5254 535.0
Characteristics 特性		S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M
319.0, 333.0 354.0, 355.0 C355.0, 380.0	4043	B B A A A A	B B A A A A A	A A A A A A	A A A A A	A A A A A	A A A A A
	4145	A A B A A A	A A B A A A				
413.0, 443.0 444.0, 356.0 A356.0, 359.0 A357.0	4043	A A A A A A	A A A A A A	A B A A A A	A B B A A	A B B A A	A B B A A
	5356			B A B B A	A A A A A	A A A A A	A A A B A
7005, 7021 7039, 7046 7146, 710.0 711.0	4043	A D C B A	A B C B A	B D C B A			
	5183	B A B A A	B A B A A	A A B A A	A A B A A	A A B A A	A A B A A
	5356	B B A A A	B A A A A	A B A A A	A B A A A	A B A A A	A B A A A
	5554	C C A A A A	C A A A A A	B C A A A A			B C A A A
	5556	B A B A A	B A B A A	A A B A A	A A B A A	A A B A A	A A B A A
6061 6070	4043	A D C A A	A B C A A	A D C A A	A D C A	A D C A	A D C A
4145	B C D B A	A B D B A					
5183	B A B A	B A B A	B A B C B	A A B A A	A A B A A	A A B A A	B A B C B
5356	B B A A	B A A A	B B A C A	A B A A A	A B A A A	A B A A A	B B A C A
5554			C C A B A B	B C A A A	B C A A A	C C A B B	C C A B B
5556	B A B A	B A B A	B A B C B	A A B A A	A A B A A	A A B A A	B A B C B
5654			C C A B A	B C A A B	B C A A B	B C A A B	C C A B A
6005, 6063 6101, 6151 6201, 6351 6951	4043	A D C A A	A B C A A	A D C A A	A B C A	A B C A	A B C A
	4145	B C D B A	A B D B A				
	5183	B A B A	B A B A	B A B C B	A A B A A	A A B A A	B A B C A
	5356	B B A A	B A A A	B B A C A	A A A A A	A A A A A	B A A C A
	5554			C C A B A B	B A A A A	B A A A A	C A A B A
5556	B A B A	B A B A	B A B C B	A A B A A	A A B A A	A A B A A	B A B C A
5654			C C A B A	B A A A B	B A A A B	C A A B B	C A A B B
5454	4043	A D C C A	A B C C A	A D C C A			
	5183	B A B B A	B A B B A	A A A B A	A A B B A	A A B B A	A A B B A
	5356	B B A B A	B A A B A	A B A B A	A B A B A	A B A B A	A B A B A
	5554	C C A A A A	C A A A A A	C C A A A A	B C A A A	B C A A A	B C A A A
	5556	B A B B A	B A B B A	A A B B A	A A B B A	A A B B A	A A B B A
5654			B C A B B			B C A A B	
511.0, 512.0 513.0, 514.0 5154, 5254 535.0	4043	A D C C	A B C C	A D C C			
	5183	B A B B A	B A B B A	A A B B B	A A B A A	A A B A A	A A B B B
	5356	B B A B A	B A A B A	A B A B A	A B A A A	A B A A A	A B A B A
	5554	C C A A A	C A A A A	C C A A B	B C A A A	B C A A A	B C A A B
	5556	B A B B A	B A B B A	A A B B B	A A B A A	A A B A A	A A B B A
5654	C C A A B	C A A A B	B C A A A	B C A A B	B C A A B	B C A A B	

Base Alloy 母材	Filler 焊丝	5454	6005, 6063 6101, 6151 6201, 6351 6951	6061 6070	7005, 7021 7039, 7046 710.0, 711.0 7146	413.0, 443.0 444.0, 356.0 A356.0, A357. 0 359.0	319.0, 333.0 354.0, 355.0 C355.0, 380. 0
Characteristics 特性		S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M
319.0, 333.0 354.0, 355.0 C355.0, 380.0	2319						B A A A A A
	4043	A A A A A A	B B A A A A	B B A A A A	B B A A A A	B B A A A A	
	4145		A A B A A A	A A B A A A	A A B A A A	A A B A A A	A B B B A A
413.0, 443.0 444.0, 356.0 A356.0, 359.0 A357.0	4043	A B B A A A	A B A A A A	A B A A A A	A B B A A A	A B A A A A	
	4145		A A B B A	A A B B A	A A B B A	A A B B A B	
	A356.0 A357.0					A A A A A A A A A A A A	
	5356	A A A B A			A A A A B		
7005, 7021 7039, 7046 7146, 710.0 711.0	4043		A D C B A	A D C B A	B D C B A		
	5183	A A B A A	A A B A A	A A B A A	A A B A A		
	5356	A B A A A	A B A A A	A B A A A	A B A A A		
	5554	B C A A A A	B C A A A A	B C A A A A	B C A A A A		
	5556	A A B A A	A A B A A	A A B A A	A A B A A		
	5654	B C A A A	B C A A A	B C A A A	B C A A A		
6061 6070	4043	A D C B A	A C B A A	A C B A A			
	4643(1)		A C B A A	A C B A A			
	5183	B A B C A	B A A C A	B A A C B			
	5356	B B A C A	B A A C A	B B A C A			
	5554	C C A A A A	C B A B B A	C B A B B B			
	5556	B A B C A	B A A C A	B A A C B			
6005, 6063 6101, 6151 6201, 6351 6951	4043	A B C B A	A C B A A				
	4643(1)		A C B A A				
	5183	B A B C A	B A A C A				
	5356	B A A C A	B A A C A				
	5554	C A A A A A	C B A B B A				
	5556	B A B C A	B A A C A				
5454	5183	A A B B A					
	5356	A B A B A					
	5554	B C A A A A					
	5556	A A B B A					
	5654	B C A B B					

Base Alloy 母材	Filler 焊丝	1060, 1070 1080, 1350	1100	2014 2036	2219	3003 ALCLAD3003	3004
Characteristics 特性		S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M
5086 5056	4043	A B C B	A B C B			A B C B	A C C B
	5183	A A B A A	A A B A A			A A B A A	A A B A A
	5356	A A A A A	A A A A A			A A A A A	A B A A A
	5556	A A B A A	A A B A A			A A B A A	A A B A A
5083 5456	4043	A B C B	A B C B			A B C B	A C C B
	5183	A A B A A	A A B A A			A A B A A	A A B A A
	5356	A A A A A	A A A A A			A A A A A	A B A A A
	5556	A A B A A	A A B A A			A A B A A	A A B A A
5052 5652	4043	A B C A A	A B C A A			A B C A A	A B C A A
	5183	B A B A	B A B A			B A B A	B A B A
	5356	B A A A	B A A A			B A A A	B A A A
	5556	B A B A	B A B A			B A B A	B A B A
5005 5050	1100	C B A A A A	C B A A A A			C C A A A A	
	4043	A A C A A A	A A C A A A			A B C A A A	A B C A A
	4145	B A D B A A	B A D B A A			B B D B A A	
	5183	C A B A B	C A B A B			C A B C B	B A B A
	5356	C A B A B	C A B A B			C A B C B	B A A A
	5556	C A B A B	C A B A B			C A B C B	B A B A
ALCLAD 3004	1100	D B A A A A	D B A A A A			C C A A A A	
	4043	A A C A A A	A A C A A A			A B C A A A	A D D A A
	4145	B A D B A A	B A D B A A			B B D B A A	
	5183	C A B C B	C A B C B			C A B C A	B A C C A
	5356	C A B C B	C A B C B			C A B C A	B B B C A
	5554						C C A B A A
	5556	C A B C B	C A B C B			C A B C A	B A C C A
3004	1100	D B A A A A	D B A A A A			C C A A A A	
	4043	A A C A A A	A A C A A A			A B C A A A	A B D A A
	4145	B A D B A A	B A D B A A			B B D B A A	
	5183	C A B A B	C A B A B			C B C A	B A C C A
	5356	C A B A B	C A B A B			C A B C A	B B B C A
	5554						C C A B A A
	5556	C A B A B	C A B A B			C B C A	B A C C A
3003 ALCLAD 3003	1100	B B A A A A	B B A A A A			B B A A A A	
	4043	A A B A A A	A A B A A A	B A A A A A	B A A A A A	A A B A A A	
	4145	A A C B A A	A A C B A A	A A B A A A	A A B A A A	A A C B A A	
2219	2319			B A A A A A	A A A A A A		
	4043	B A A A A A	B A A A A A	B C B C A A	B C B C A A		
	4145	A A B A A A	A A B A A A	A B C B A A	A B C B A A		
2014 2036	2319			C A A A A A			
	4043	B A A A A A	B A A A A A	B C B C A A			
	4145	A A B A A A	A A B A A A	A B C B A A			
1100	1100	B B A A A A	B B A A A A				
	4043	A A B A A A	A A B A A A				
1060, 1070 1080, 1350	1100	B B A A A B					
	1188	C C A A A A					
	4043	A A B A A A					

Base Alloy 母材	Filler 焊丝	ALCLAD 3004	5005 5050	5052 5652	5083 5456	5086 5056
Characteristics 特性		S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M	S Z D C T M
5086 5056	4043	A C C B	A B C B			
	5183	A A B A A	A A B A A	A A B A A	A A B A A	A A B A A
	5356	A B A A A	A A A A A	A B A A A	A B A A A	A B A A A
	5554			C C A A A		
	5556	A A B A A	A A B A A	A A B A A	A A B A A	A A B A A
	5654			B C A A B		
5083 5456	4043	A C C B	A B C B			
	5183	A A B A A	A A B A A	A A B A A	A B A A A	
	5356	A B A A A	A A A A A	A B A A A	A A A A A	
	5554			C C A A A		
	5556	A A B A A	A A B A A	A A B A A	A A B A A	
	5654			B C A A B		
5052 5652	4043	A C C A A	A B C A A	A D C B A		
	5183	B A B A	B A B A	A A B C B		
	5356	B B A A	B A A A	A B A C A		
	5554			C C A A A B		
	5556	B A B A	B A B A	A A B C B		
	5654			B C A B A		
5005 5050	1100		B A A A A			
	4043	A B C A A	A B D A A			
	5183	B A B B A	B A C B			
	5356	B A A B A	B A B B			
	5556	B A B B A	B A C B			
	4043	A D D A A				
ALCLAD 3004	5183	B A C C A				
	5356	B B B C A				
	5554	C C A B A A				
	5556	B A C C A				

Note: Yellow means base alloy; Blue means welding wire; Gray means characteristic.  
 表格说明: 黄色为母材; 蓝色为焊丝; 灰色为匹配度。

Note:

- S: Ease of welding
- Z: Strength of welding joint
- D: Ductility
- C: Corrosion resistance
- T: Service at sustained temperatures above 150(°F) ≈ 65.5(°C).
- T: 温度高于150华氏度(°F) ≈ 65.5摄氏度(°C)推荐适用
- M: Color match after anodizing.
- S: 匹配适用, 抗裂
- Z: 强度
- D: 韧性
- C: 耐(腐)蚀性
- M: 阳极氧化处理色差

Characteristics—A: best; B: good; C: normal; D: poor; (blank means can't choose).  
 焊接技术特性 —A: 最佳; B: 较好; C: 一般; D: 差; (无对应表示不能选择)