

ALU 1Mn

Electrodes MMA [SMAW]

Aluminium alloys

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 18273-A : Al 3103 (ALMn1) DIN 1732 : EL-AlMn1 AWS A-5.3 : E 3003 W.Nr. : 3.0516		Constructions & Engineering Metallurgy (Steelworks) Shipbuilding&Offshore

Aluminum electrode for welding aluminum-manganese and aluminum-magnesium alloys.
Excellent for welding various grades of aluminum up to 3% Mg content.

Application

Containers in the food and brewing industry, ship structures (masts).

Reconstruction of damaged elements.

Seawater resistant weld metal.

Base material

W.Nr	EN/DIN	PN	ISO/EN
3.0506	ALMn0,6		5005
3.0515	AlMn		3103
3.3315	AlMg1	PA43	5005A
3.3318	Al99,9Mg1		5505
3.3328	Al99,9Mg2		
3.3527	AlMgMn		5049
3.3535	AIMg3	PA11	5754
3.3541	G-AlMg3		5110
3.0525	AlMn1Mg0,5		3005
3.0526	AlMn1Mg1		3004

Typical chemical composition %

Si	Mn	Fe	ΑΙ
0,40	1,3	0,30	98,0

Typical mechanical properties			
Yield strength Re [N/mm2]	>80		
Tensile strength Rm [N/mm2]	150		
Elongation A5 [%]	>10		
Hardness	app. 25HB /		
Coating type	special alkaline		
Welding current	= +		
Welding positions			

Redrying	110°C / 2 h
Additional description	Due to the high hygroscopicity of the coating, the product should be stored in clean and dry places. Welding instruction: Start welding at approximately 130% of standard current (Hot Start). Hold the electrode at right angles to the material to be welded. Weld on a very short arc, they move forward quickly. Materials thicker than 5 [mm] should be preheated to about 100-200 [°C]. A high bead indicates too cold base material or too low welding parameters. The remains of the slag formed should be very well cleaned from the face of the weld.

Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	350 /	60-90	2,0	8,0	106
3,2	350 /	80-110	2,0	8,0	74
4,0	350 /	110-150	2,0	8,0	51

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