



## ALU 99,8

Electrodes MMA [SMAW]

Aluminium alloys

<b>CLASSIFICATION:</b>		<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 18273-A : E Al 99,5 (Al1100) DIN 1732 : EL-Al 99,5 AWS A-5.3 : E 1100 W.Nr. : 3.0259			Constructions & Engineering Metallurgy (Steelworks)
<ul style="list-style-type: none"><li>• Electrode for welding pure aluminum and its alloys (maximum 0.5% of alloying elements).</li><li>• Recommended for welding tanks, apparatus.</li><li>• Ideal for cladding, maintenance and rebuilding of parts.</li><li>• The deposit is corrosion resistant.</li></ul>			
Application			
Connectors where the base material is pure aluminum. Repair of defects in aluminum castings.			
Base material			
EN/DIN	W.Nr.	PN	ISO/EN
1200	3.0205	A2	1200
1050A	3.0255	A1	1050A
1070A	3.0275	A0	1070A
1080A	3.0285	A00	1080A
AlMn			
AlMgSi			
Typical chemical composition %			
Si	Fe	Al	
0,30	0,20	>99,5	
Typical mechanical properties			
Yield strength Re [N/mm2]	>30		
Tensile strength Rm [N/mm2]	150		
Elongation A5 [%]	>25		
Hardness	23[HB] /		
Coating type	special alkaline		
Welding current			
Welding positions			
Redrying	110°C / 2 h		

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

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 [A] (hard current start). Hold the electrode at right angles to the material to be welded. On a very short arc, they move forward quickly. Materials thicker than 5 [mm] should be

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs./kg
2,5	350 /	60-90	2,0	8,0	106
3,2	350 /	70-110	2,0	8,0	74
4,0	350 /	110-150	2,0	8,0	51

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