

EL-ALMn1

CATEGORY	SMAW Stick Electrodes
TYPE	Coated Manganese alloyed aluminium electrode.
APPLICATIONS	Joining aluminum alloys such as broken parts and or other casting parts, also ideal for cladding or rebuilding parts. • Aluminum alloyed with Manganese, copper, silicon, and magnesium. • Also excellent for welding dissimilar grades of Aluminum. • Storage tanks, truck and trailer parts, chemical tanks, food equipment.
PROPERTIES	Very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up. Increased strength and excellent ductility due to Mn content Excellent corrosion resistance. Welding instructions: Start the electrode with about 130% hot start and hold the electrode straight while moving quickly forward and keep a very short arc.

CLASSIFICATION	AWS	5.3: E 3003
	EN ISO	no standard
	DIN: W.Nr.	3.0515
	DIN	1732: EL-ALMn1

SUITABLE FOR	Seawater resistant aluminium, AlMn, AlMg alloys with max. 3% magnesium, • AlMn0,6, AlMn1, AlMg1Mg0,5, AlMn1Mg1, AlMg3
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WELDING POSITIONS:



WELD METAL ANALYSIS %

Si	Cu	Fe	Mg	Mn	Zn	Al
0.3	0.1	0.35	0.2	1.2	0.05	rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW	145	152	8				40

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A) DC+ only	kg / can	kg / 6pack
2.5	350	50-80	2	12
3.2	350	70-120	2	12
4.0	350	110-150	2	12