



## ALU 1Mn

Electrodes MMA [SMAW]

Aluminium alloys

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>	
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	
<ul style="list-style-type: none"><li>Aluminum electrode for welding aluminum-manganese and aluminum-magnesium alloys.</li><li>Excellent for welding various grades of aluminum up to 3% Mg content.</li></ul>			
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	AlMg3	PA11	5754
3.3541	G-AlMg3		5110
3.0525	AlMn1Mg0,5		3005
3.0526	AlMn1Mg1		3004
Typical chemical composition %			
Si 0,40	Mn 1,3	Fe 0,30	Al 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			

<b>Redrying</b>	110°C / 2 h
<b>Additional description</b>	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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