ALU 99,8

Electrodes MMA [SMAW]

Aluminium alloys

CLASSIFICATION:	APPROVALS:	APPLICATION:
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)

- Electrode for welding pure aluminum and its alloys (maximum 0.5% of alloying elements).
- Recommended for welding tanks, apparatus.
- Ideal for cladding, maintenance and rebuilding of parts.
- The deposit is corrosion resistant.

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% of standard current (hot start). Hold the electrode at right angles to the material to be welded. Weld on a very short arc, do not 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/1 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

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl