

## E Al 99,8

CATEGORY	SMAW Stick Electrodes
TYPE	Coated electrode for rapidly joining aluminum and aluminum alloys.
APPLICATIONS	Joining pure aluminum and alloys with maximum 0,5 % alloying elements in construction and or in maintenance, also ideal for cladding or rebuilding parts. Can be used for flame welding as well.
PROPERTIES	<p>Very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up.</p> <p>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.</p>

CLASSIFICATION	AWS	5.3: E 1100
	EN ISO	no standard
	DIN: W.Nr.	3.0259
	DIN	1732: EL-AL 99,8

SUITABLE FOR aluminium, pure

WELDING POSITIONS:



WELD METAL ANALYSIS %

Al  
> 99.5

MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A5 (%)	Melting range °C
AW	>40	>70	>25	647-658

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A) DC + only	kg / can	kg / 6 pack
2.0	250	40	2	12
2.5	350	70	2	12
3.2	350	110	2	12
4.0	350	135	2	12