

## E AIMn1

**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-AIMn1

**SUITABLE FOR** Seawater resistant aluminium, AIMn, AIMg alloys with max. 3% magnesium, • AIMn0,6, AIMn1, AIMg1Mg0,5, AIMn1Mg1, AIMg3

**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 <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	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