

Brand Name & Classification

AWS/ASME SFA-5.3: E 1100
DIN 1732: EL-AI 99,5

Properties

Electrode with special covering for the welding of pure aluminium. Electrode should be held perpendicular to the work piece and a short arc length maintained. Plates thicker than 10mm and larger work pieces require preheating in the range of 150 – 250^o c. Since slag residues are corrosive, they must be completely removed from the weld bead. Electrode serves well as consumable in oxyacetylene welding. The covering being hygroscopic, the electrodes must be stored in an absolutely dry location, or redried as required.

Application

Commercially pure aluminium e.g. Al 99.5 to Al 99. DIN 1712
Aluminium Alloys such as Al99.9 Mg 0.5, AIR Mg 0.5 DIN 1725

Weld Metal Analysis Typical values

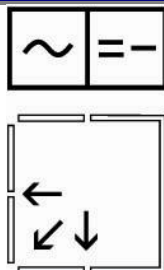
Aluminium: 99.5 Min

Others: 0.5 Max

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation
>30 N/MM ²	80 N/mm ²	>30 %

Welding Current & Positions



Current

Dia	Length	Amperes
2.5	300	60-90
3.2	350	80-110
4.0	350	110-150