



Product Data Sheet

E 'Manual metal-arc welding'

OK AIMn1

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REASON FOR ISSUE

Economy data added.

GENERAL

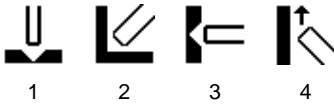
Covered electrode suitable for welding of Mn-alloyed aluminium and aluminium alloys containing up to 3 % Mg, e.g. EN AW-3103, 3207, 3003, 5005.

Polarity: DC+

Alloy Type: Aluminium alloy AIMn1

Coating Type: Chloride and Fluoride Salt

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN ISO 18273 AIMn1

APPROVALS

Not applicable

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
Si		0.50
Mn	0.9	1.5
Al	96.5	99.0
Fe		0.70

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
\varnothing x Length										
2.4 x 350	50	90	0.90	31	0.41	294	0.51	24	25	1,2,3,4
3.2 x 350	70	120	1.40	61	0.89	88	1.74	23	21	1,2,3,4

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)

OTHER DATA

Redrying: 120 °C, 1h.