

OK AlMn1

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.

Specifications	
Classifications	EN ISO 18273 : AlMn1

Welding Current	DC+
Alloy Type	Aluminium alloy AlMn1
Coating Type	Chloride and Fluoride Salt

Typical Weld Metal Analysis %			
Mn	Si	Al	Fe
1.3	0.1	98.1	0.3

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.4 x 350.0 mm	50-90 A	25 V	41 %	24 sec	0.51 kg/h
3.2 x 350.0 mm	70-120 A	21 V	89 %	23 sec	1.74 kg/h