

## CARBO AIMn

<b>International standards</b>	Material No.	3.0516
	DIN 1732	EL-AIMn 1

**Approvals** ---

**Characteristics** Special coated electrode for joining wrought aluminium-manganese and aluminium alloys up to 3% Mg content.

**Welding instructions** The welding area has to be thoroughly cleaned, the seam flanks should shine metallic bright CARBO AIMn is easy to weld and to deslag. In order to obtain a dense, non-porous weld, the electrode should be preferably welded in horizontal position, with a short arc and at high speed. Preheat the welding area of massive work-pieces to 150 – 250° C. A single layer, without layering, is recommended.

**Storage** WARNING: Aluminium electrodes are very sensitive to humidity pick-up, since their coating contains hygroscopic salts, therefore, storage in a dry place is very important. Electrodes which have picked-up humidity must be dried (see „Rebaking“).

**Operating temperature** ---

<b>Base materials</b>	3.0506	AlMn0,6	3.3328	Al99,9Mg2
	3.0515	AlMn	3.3527	AlMgMn
	3.3315	AlMg1	3.3535	AlMg3
	3.3318	Al99,9Mg1	3.3541	G-AlMg3

<b>Mechanical properties of all-weld metal</b>	<b>Tensile strength</b>	<b>Yield strength</b>	<b>Elongation</b>
	<b>R<sub>m</sub> N/mm<sup>2</sup></b>	<b>R<sub>p0,2</sub> N/mm<sup>2</sup></b>	<b>A<sub>5</sub> %</b>
( typical values)	110	40	20

<b>Weld metal analysis</b>	<b>Al</b>	<b>Mn</b>	<b>Mg</b>
(typical, wt. %)	Basis	1,2	0,2

**Current** = +

**Welding positions** PA, PB, PC, PF

**Rebaking** 1 h, 120 °C + / - 10 °C ( if required)

<b>Dia./Length</b>	<b>Amperage (A)</b>	<b>Pcs./packet</b>	<b>Pcs./carton</b>	<b>kg/1000</b>	<b>kg/packet</b>	<b>kg/carton</b>
2,5 x 350	50 - 80	222	889	9,0	2,0	8,0
3,2 x 350	70 - 100	143	571	14,0	2,0	8,0
4,0 x 350	100 - 130	87	348	23,0	2,0	8,0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.