

# 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> ( typical values)	<b>Tensile strength</b> $R_m$ N/mm <sup>2</sup>	<b>Yield strength</b> $R_{p0,2}$ N/mm <sup>2</sup>	<b>Elongation</b> $A_5$ %
	110	40	20

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

**Current** = +

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

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

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
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