

**ALU 99,5**

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**ELECTRODES**  
(SMAW)**CLASSIFICATION:**

EN ISO 18273-A: E Al 99,5 (Al1100)

DIN 1732: EL-Al 99,5

AWS A-5.3: E 1100

W.Nr.: 3.0259

**DESCRIPTION:**

- Electrode for welding pure aluminum and its alloys (maximum 0.5% of alloying elements).
- Recommended for welding tanks, apparatus.
- Ideal for cladding, maintenance and rebuilding of parts.
- The deposit is corrosion resistant.

**APPLICATION:**

Connectors where the base material is pure aluminum. Repair of defects in aluminum castings.

**BASE MATERIAL:**

EN/DIN	W.Nr.
1200	3.0205
1050A	3.0255
1070A	3.0275
1080A	3.0285
AlMn	
AlMgSi	

**TYPICAL CHEMICAL COMPOSITION (%):**

Si 0,30 Fe 0,20 Al &gt;99,50

**TYPICAL MECHANICAL PROPERTIES:****Re:** >30 N/mm<sup>2</sup>**Rm:** 150 N/mm<sup>2</sup>**A5:** 25%**Hardness:** 23 HB

Due to the high hygroscopicity of the coating, the product should be stored in clean and dry places.

**Coating:** special alkaline**Redrying:** 110°C / 2 h

Welding parameters			Packing		
φ	Length [mm]	Current [A]	Weight of packet [kg]	Weight of carton[kg]	Pcs/1 kg
2,5	300	60-90	2,0	8,0	106
3,2	350	70-110	2,0	8,0	74
4,0	350	110-150	2,0	8,0	51

Read more about this product: <https://www.metalweld.pl/en/alu-995>