

# OK AIMn1



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

<b>Classifications:</b>	EN ISO 18273:AIMn1
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<b>Welding Current:</b>	DC+
<b>Alloy Type:</b>	Aluminium alloy AIMn1
<b>Coating Type:</b>	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	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.4 x 350 mm	50-90 A	25 V	0.41	294	24 s	0.51 kg/h
3.2 x 350 mm	70-120 A	21 V	0.89	88	23 s	1.74 kg/h