

Welding of aluminium profiles and plates**CLASSIFICATION**DIN 1732 (Si-AlMn)
A5.3 (E 3003)**GENERAL DESCRIPTION**

Welding of aluminum and aluminum alloys.
No discoloration of the weld after anodizing.
Good bond on the base metal, very good releasing of the slag.
Low spatter. Pore-free.
(We recommend using Lastek 62 for welding aluminum-silicon castings.)

TYPICAL USE

Can be used for welding of pure aluminum, AlMgSi, AlMn, AlMg1 and AlMg3.
Chemical and food industry, fish processing industry, transportation (trucks, construction of containers, etc ...)

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Si 0.4	Fe 0.3	Mn 1.3	Al Balance			
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MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ² ≥ 150 MPa	Tensile Strength N/mm ² ≥ 250 MPa	Elongation 5d (%) ≥ 10%	Impact Strength Charpy V notch (ISO-V)
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General information

Welding positions: PA, PB, PC
Shielding gas: NA
Dia (x length) (mm): 2.5 - 4.0 (x 350)
Packing: 2.5 kg in plastic box
Polarity: DC reverse polarity (electrode positive)
Tips & tricks: Hold the electrode perpendicular to the workpiece. Use a short arc.
High travel speed. Preheat thick pieces to 150 - 200 ° C.
Always use dry electrodes.
Remove the slag thoroughly to avoid corrosion.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.