

CARBO AI 99,8

International standards	Material No.	3.0286
	DIN 1732	EL-AI 99,8

Approvals ---

Characteristics Special coated electrode for welding pure aluminium and cast aluminium alloys.

Welding instructions The welding area has to be thoroughly cleaned, the seam flanks should shine metallic bright. AlSi 5 is easy-to-weld and to de-slag. 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 ---

Base materials Al 98 Al 99 Al 99,5 Al 99,7 Al 99,8
DIN 1712

Mechanical properties of all-weld metal (typical values)	Tensile strength R_m N/mm ²	Yield strength $R_{p0,2}$ N/mm ²	Elongation A_5 %
	85	55	25

Weld metal analysis (typical, wt. %)	Al	Others
	Bal.	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	40 - 70	222	889	9,0	2,0	8,0
3,2 x 350	60 - 100	142	567	14,1	2,0	8,0
4,0 x 350	90 - 130	99	394	20,3	2,0	8,0

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