



# CEWELD E AlMn1

**TYPE** Coated Manganese alloyed aluminium electrode.( AlMn1(Cu), Al 3103)

**APPLICATIONS** **CEWELD®E AlMn1** is suitable for joining aluminum alloys alloyed with manganese, copper, silicon and magnesium. Also excellently suited for joining different types of aluminum and for seawater applications. Suitable for storage tanks, truck and trailer parts, chemical tanks, food equipment. Also for build-up and repair welding e.g. on fractions and/or other castings. castings.

**PROPERTIES** **CEWELD®E AlMn1** has very good weldability with good penetration and porosity-free weld metal, unique self-lifting slag and improved coating against moisture absorption. **CEWELD®E AlMn1** shows increased strength and excellent ductility due to the Mn content as well as excellent corrosion resistance. Welding instructions: Start with the upper part of the amperage range. Feed the electrode rapidly and move quickly to maintain a very close arc gap.

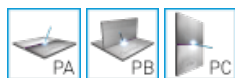
**CLASSIFICATION**

|        |                  |
|--------|------------------|
| AWS    | A 5.3: E 3003    |
| EN ISO | 18273: E AlMn1Cu |
| W.Nr.  | 3.0515           |
| F-nr   | 21               |

**SUITABLE FOR** **Al 3103 (AlMn1(Cu)) 3.0516**  
Seawater resistant Aluminium, AlMn, AlMg alloys with max. 3% magnesium,  
**Mat.n:** 3.0506, 3.0515, 3.3315, 3.3318, 3.3328, 3.3527, 3.3535, 3.3541, 3.0525, 3.0526  
AlMn0,6, AlMn, AlMn1, Al99,9Mg1, Al99,9Mg2, AlMgMn, AlMg1Mg0,5, AlMn1Mg1, AlMg3, G-AlMg3  
**Iso. n:** 5005, 3103, 5005A, 5505, 5049, 5754, 5110, 3005, 3004

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| Si   | Mn  | Fe   | Cu  | Zn   | Al   |
|------|-----|------|-----|------|------|
| 0.15 | 1.2 | 0.25 | 0.1 | 0.05 | Rem. |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      | 50                      | 115                  | 18                 | HRc      |

**REDRYING** Not required

**GAS ACC.** EN ISO 14175



# CEWELD E AlMn1

E ALMN1 2,5 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2       | 8720663406774 |

E ALMN1 3,2 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2       | 8720663406781 |

E ALMN1 4,0 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2       | 8720663406798 |