



CEWELD E AlMn1

TYPE	Coated Manganese alloyed aluminium electrode. (AlMn1(Cu), Al 3103)													
APPLICATIONS	<p>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.</p>													
PROPERTIES	<p>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.</p>													
CLASSIFICATION	AWS	A 5.3: E 3003												
	EN ISO	18273: E AlMn1Cu												
	F-nr	21												
	W.Nr.	3.0515												
	W.Nr.	3.0516												
SUITABLE FOR	<p>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</p>													
APPROVALS	No Approvals Found													
WELDING POSITIONS														
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><tr><td>Si</td><td>Mn</td><td>Fe</td><td>Cu</td><td>Zn</td><td>Al</td></tr><tr><td>0.15</td><td>1.2</td><td>0.25</td><td>0.1</td><td>0.05</td><td>Rem.</td></tr></table>		Si	Mn	Fe	Cu	Zn	Al	0.15	1.2	0.25	0.1	0.05	Rem.
Si	Mn	Fe	Cu	Zn	Al									
0.15	1.2	0.25	0.1	0.05	Rem.									
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)										
	As Welded /	50	115	18										
REDRYING TEMPERATURE	Not required													
GAS ACCORDING EN 14175														



CEWELD E AlMn1

E ALMN1 2,5 X 350MM

Type	KG/unit	EANCode
Can	2	8720663406774

E ALMN1 3,2 X 350MM

Type	KG/unit	EANCode
Can	2	8720663406781

E ALMN1 4,0 X 350MM

Type	KG/unit	EANCode
Can	2	8720663406798