

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 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 AI 98 AI 99 AI 99,5 AI 99,7 AI 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