

# EAL 1100

Coated Electrode for Aluminium Alloys -

Standards	
AWS/ASME SFA - 5.3	E1100
EN ISO 18273	E Al 1080 A(AI 99.8)
TS EN ISO 18273	E Al 1080 A(AI 99.8)
TS 9604	EL-AI99.5
DIN M. No.	3.0286

Approvals & Certificates
GOST

Materials	
DIN	Material
Al 99.0 - Al 99.5	3.0205 - 3.0255
Al 99.9 Mg 0.5	3.3308

## Properties and Applications

Special coated electrode for welding pure aluminium. Weld metal has good color matching with base metal and high electrical conductivity. Hold the electrode perpendicularly to workpiece, with a short arc length, during welding. If the thickness is greater than 10 mm or in large workpieces, preheating shall be applied between 150°C to 250°C. Since slag residues are corrosive, they must be completely removed from the weld bead. Electrode serves well as consumable in oxyacetylene welding. The covering being hygroscopic, electrodes must be stored in an absolutely dry location, or redried if required.



## Typical Chemical Values of Weld Metal

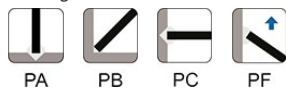
Type of Analysis	Al
Weld Deposit	99.80

## Typical Mechanical Values of Weld Metal

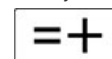
Test Condition	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)
As welded	55	85	25

## Application Information

### Welding Positions



### Polarity:



### Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x350	50-80
3.25x350	70-120
4.00x350	110-150

## Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
14000HYEM2	2.50x350	216 pcs	2.12	3	6.50	Tin Box
14000NYEM2	3.25x350	146 pcs	2.12	3	6.50	Tin Box
14000QYEM2	4.00x350	102 pcs	2.12	3	6.50	Tin Box

## Storage & Re-Drying Information

It has to be dried at 120°C for 2 hour.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.