Union AlMn 1

TIG rod, aluminium

Classifications

EN ISO 18273	AWS A5.1 / SFA-5.1
S Al 3103 (AlMn1)	ER3103

Characteristics and typical fields of application

Solid rod for GTAW with 1.5% Mn for joining of aluminium-manganese alloys and aluminium-magnesium alloys with a Mg content of approx. 3% according to EN ISO 18273.

Base materials

AlMn0.6 3.0506
AlMn 1 3.0515
AlMn 1 Mg0.5 3.0525
AlMn 1 Mg 13.0526
AlMg3 3.3535

Typical analysis

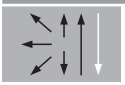
	Si	Mn	Cr	Fe	Al	Mg
wt.-%	<0.5	0.9 – 1.5	<0.1	<0.7	Rest	<0.3

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)
	MPa	MPa	%
u	≥35	≥ 90	≥24

u untreated, as welded

Operating data



Polarity	AC
Shielding gas (EN ISO 14175)	I1 I2

Dimension mm
1.6 × 1000
2.0 × 1000
2.4 × 1000

For wall thickness above 6 mm preheating up to 100 – 250ºC is necessary to get a good fusion to the base material. Superelevated seams indicates too less preheating.

Approvals

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