

Aluminium based alloys											
Type / code		Covered electrodes									
		3.0286	3.0516	3.2245	3.2585						
Filler metal		EL-AI99,8	EL-AIMn1	EL-AISi5	EL-AISi12						
		CARBO AL 99,8	CARBO ALMN	CARBO AISi 5	CARBO AISi 12						
Base metal											
3.0285	Al99,8	●									
3.0275	Al99,7	●									
3.0257	E-Al	●									
3.0255	Al99,5	○									
3.0205	Al99	●									
3.0506	AlMn0,6		●								
3.0515	AlMn1		●								
3.0517	AlMnCu		●								
3.3315	AlMg1		○		○						
3.3326	AlMg1,8				○						
3.3535	AlMg3				○						
3.3527	AlMg2Mn0,8				●						
3.3206	AlMgSi0,5			①							
3.3210	AlMgSi0,7			①							
3.2305	AlMgSi			①							
3.2315	AlMgSi1			①							
3.3211	AlMg1SiCu			①							
3.2581	G-AISi12				●						
3.2583	G-AISi12(Cu)				●						
3.2211	G-AISi11				①						
3.2381	G-AISi10Mg				○						
3.2383	G-AISi10Mg(Cu)				○						
3.2373	G-AISi9Mg				○						
3.2371	G-AISiMg				○	○					
3.2341	G-AISi5Mg				○	○					
3.2161	G-AISi8Cu3				●						
3.2151	G-AISi6Cu4				●	○					
3.3241	G-ALMg3Si				●						

● very suitable

① suitable, anodic oxidation (anodize)  
after anodising discoloration of the seam will occur.

○ suitable