



AMA 1420 N

Standards: EN 499 E 46 62 Ni B 42 H5
 DIN 8529 E SY 42 87 2 Ni B H5
 AWS/ASME SFA - 5 5 E 8018 - C 1 - H4

Application / Properties: Electrode for producing crack-free and tough welded joints. Weld metal is extremely metallurgical purity having very low hydrogen content. Welds are of X-ray quality.

Weld metal analysis in % (Typical values):

C	Mn	Si	P	S	Ni
0.05	1.1	0.3	<0.02	<0.02	2.4

Mechanical Properties of all-weld metal (Single values are typical values):

	Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation A5 (%)	Impact energy (J) ISO - V + 20 °C - 60 °C	
AW	550-700	>480	>22	170	100
SR	520-640	>420	>20	170	80

AW: as welded

SR: stress - relieved 15hrs./580C



Welding Parameters

Diameter (mm)	2.5	3.25	4.0	5.0
Length (mm)	350	350-450	350-450	450
Amperage(A)	65 - 95	90 - 130	140 - 185	180 - 245



Materials:

DIN Standard	TS1E 355 to TS1E 460 ; ES1E 355 to ES1E 460 ; ES1E 255 to StE 460 ; TS1E 355 to TS1E 460 ; WSTE 355 to WSTE 460
EN Standard	12Ni14 ; 14Ni6 ; 10Ni14 ; 13MnNi 6 3 ; P355NL1 to P460NL 1 ; S255N to S460N ; S355NH to S460NH ; S255NL to S460NL ; S255NL1 to S380NL1
ASTM Standard	A633 Gr. E ; A572 Gr. 65 ; A203 Gr. D ; A333 and A334 Gr. 3 ; A 350 Gr. LF3

Rebaking : required at 300°C to 350°C for 2hrs.

Approval: LRS , GL