



# AMA ١١٨٩N

AWS/ASME SFA-٥.٥  
EN ٤٩٩

E ٨٠١٨-G-H٤  
E ٥٠٤ MnMo B ٤٢ H٥

### Application/properties:

Basic electrode used for welding high strength, low-alloyed steel. The electrode is designed for various applications, including pipelines. Weld metal is extremely metallurgical pure having very low hydrogen content. The electrode has a stable and concentrated arc, thus being well-suited for positional welding. Welds are of X-ray quality.

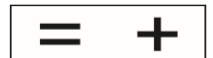
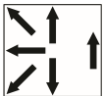
### Weld metal analysis in % (typical values):

| C    | Mn  | Si  | Ni  |
|------|-----|-----|-----|
| ٠.٠٧ | ١.٥ | ٠.٤ | ٠.٤ |

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

| Tensile Strength<br>(N/mm <sup>٢</sup> ) | Yield Strength<br>(N/mm <sup>٢</sup> ) | Elongation<br>A٥ (%) | Impact energy (J)<br>ISO-V<br>-٦٠°C |
|------------------------------------------|----------------------------------------|----------------------|-------------------------------------|
| ٦٣٠                                      | ٥٤٠                                    | ٢٦                   | ٦٠                                  |

| Welding Parameters |             |              |
|--------------------|-------------|--------------|
| Diameter (mm)      | Length (mm) | Amperage (A) |
| ٢.٥                | ٣٥٠         | ٦٥ - ٩٥      |
| ٣.٢٥               | ٤٥٠         | ٩٠ - ١٤٠     |
| ٤.٠                | ٤٥٠         | ١٤٠ - ١٨٥    |
| ٥.٠                | ٤٥٠         | ١٨٠ - ٢٤٠    |



### Remarks:

- Just Consume Dry Electrode
- Rebaking: required on ٣٠٠°C to ٣٥٠°C for ٢ hours.