



AMA ١٢٩٨N

AWS/ASME SFA-٥.٥
EN ISO ٢٥٦٠-A

E ٧٠١٨-G-H٤
E ٣٨ ٥ Z B ٤٢ H٥

Application/properties:

Basic electrode used for welding fine-grained steels used in pressure vessels, boilers, pipes, steel structures, dam construction and shipbuilding. Its weld is tough and crack-resistant and has 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):

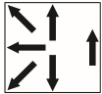
C	Mn	Si	Ni	S	P
٠.٠٦	١.٣	٠.٥	٠.٤٥	< ٠.٠٢	< ٠.٠٢

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

Heat treatment	Tensile Strength (N/mm ^٢)	Yield Strength (N/mm ^٢)	Elongation A٤ (%)	Impact energy (J) ISO-V
				-٥٠°C
T	٤٩٠-٥٦٠	> ٤٠٠	> ٢٣	> ١٣٠

T: Tempered ١ hour at ٢٢٠°C, air cooling

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
٢.٥	٣٥٠	٦٥ - ٩٥
٣.٢٥	٤٥٠	٩٠ - ١٣٥
٤.٠	٤٥٠	١٤٠ - ١٨٠
٥.٠	٤٥٠	١٩٠ - ٢٤٠



Rebaking:

- Required at ٣٠٠°C to ٣٥٠°C for ٢ hours
- Preheating, inter pass temperature and post weld heat treatment in accordance with base metal to be welded.