AMA ١٤٣٥NA

MIL **E ١٠٠١٨-M١-H٤R**

Application/properties:
Low hydrogen basic electrode with high strength and good impact strength is used for welding high strength steels HY٨٠. The hydrogen content in the weld pool is at the minimum possible standard and the electrode coating using nano materials is resistant to moisture absorption in humid environments with ٨٠٪ humidity for ٩ hours. This electrode meets the stringent requirements of the T٩٠٧٤-BC-GIB-٠١٠/٠٢٠٠ standard.

Weld metal analysis in % (typical values):

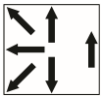
C	Mn	Si	Mo	Ni	P	S
٠.٠٤	١.٤	٠.٤	٠.٢٨	٢,٢	٠,٠١	٠,٠١

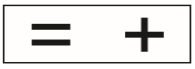
Mechanical Properties of all-weld metal:
(single values are typical values)

Heat treatment	Tensile Strength (N/mm٢)	Yield Strength (N/mm٢)	Elongation A٤ (%)	Impact energy (J) ISO-V	
				-١٨°C	-٥١°C
AW	>٦٨٠	٦٢٠-٧٥٠	٢٠	>١١٠	>٥٥

AW : As weld

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
٢،٥	٣٥٠	٦٥ - ٩٠
٣،٢٥	٤٥٠	٩٠-١٣٠
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.