



AMA ١٥٦ JB

AWS/ASME SFA-٥,٤ E ٣١٦ H-١٦
Comparable No.of material ١,٤٤٣٠
DIN ٨٥٥٦ E ١٩ ١٢ ٣ R ٢٦
prEN ١٦٠٠ E ١٩ ١٢ ٣ H R ١٢

Application/properties:

Rutile electrode is suitable for welding cast steels or high carbon austenitic chromium-nickel-molybdenum stainless steels. Some of its properties are fine droplet metal transfer, good wash-in of joint sides, finely-rippled bead surface, easily removable slag, easy arc striking and restriking.

Weld metal analysis in % (typical values):

C	Mn	Si	Cr	Ni	Mo
٠,٠٦	٠,٦	٠,٧	١٩	١٢	٢,٧

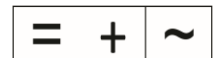
Mechanical Properties of all-weld metal: (single values are typical values)

Tensile Strength (N/mm ^٢)	Yield Strength ٠,٢% (N/mm ^٢)	Elongation A٥ (%)	Impact energy(j) ISO - V
			+٢٠°C
٦٠٠	٤٢٠	>٣٠	٦٠

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
٢,٥	٢٥٠	٤٥ - ٨٠
٣,٢٥	٣٥٠	٧٠ - ١٢٠
٤,٠	٣٥٠	١٠٠ - ١٥٠
٥,٠	٣٥٠	١٤٠ - ٢١٠



OCV>٧٠V



Remarks:

- Just Consume Dry Electrode
- Rebaking: required on ٣٥٠°C to ٤٠٠°C for ٢ hours.