



AMA ١٦٦٠ JB

AWS/ASME SFA-٥,٤ E ٣١٦-١٦
DIN ٨٥٥٦ E ١٩ ١٢ ٣ R ٢٦
prEN ١٦٠٠ E ١٩ ١٢ ٣ R ١٢

Application/properties:

This electrode is suitable for welding of austenitic stainless Cr-Ni-Mo-steels. It's suitable for operating temperatures up to +٤٠٠°C. 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
٠,٠٤	٠,٨	٠,٩	١٨,٥	١٢	٢,٧

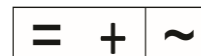
Mechanical Properties of all-weld metal: (single values are typical values)

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



Materials:

DIN EN Standard	١.٤٤٠.١ X٥CrNiMo ١٧ ١٢ ٢; ١.٤٤٠.٤ X٢CrNiMo ١٧ ١٣ ٢ G-X٢CrNiMoN ١٨ ١٠; ١.٤٤٢.٩ X٢CrNiMoN ١٧ ١٣ ٣; ١.٤٤٠.٦ X٢CrNiMoN ١٧ ١٢ ٢; ١.٤٤٠.٨ G-X٥CrNiMo ١٨ ١٠; ١.٤٤٣.٦ X٥CrNiMo ١٧ ١٣ ٣; ١.٤٥٨.١ G-X٥CrNiMoNb ١٨ ١٠; ١.٤٤٣.٥ X٢CrNiMo ١٨ ١٤ ٣; ١.٤٥٧.١ X٢CrNiMoTi ١٧ ١٢ ٢; ١.٤٥٨.٠ X٢CrNiMoNb ١٧ ١٢ ٢; ١.٤٥٨.٣ X١٠CrNiMoNb ١٨ ١٢
Other Standard	S٣١٦٥٣; AISI ٣١٦L; ٣١٦Ti; ٣١٦Cb

Rebaking: required at ٣٥٠°C to ٤٠٠°C for ٢ hours.