



AMA 16Cr11

DIN 8000

E 16-UM-00

Application/properties:

basic-covered electrode is suitable for hard facing cutting edges, press dies, dredging pump parts and liners that are subject to wear at high temperatures. The weld metal has an austenitic structure that has relatively good wear resistance at high temperatures.

Weld metal analysis in % (typical values):

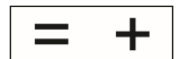
C	Cr	Mn	Si
0.20	12.7	1.30	0.5

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

Hardness as-welding (HV 30)

530-590 (51 - 55 HRC)

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
2.0	300	70 - 90
3.20	400	100 - 130
4.0	400	140 - 180
5.0	400	190 - 240



Suitable for: Hard facing of cutting edges, press dies, dredging pump parts and high temperature liners

Rebaking: Required at 300°C to 350°C for 2 hours.