



AMA ١٠١٦F

AWS/ASME SFA-٥,١
EN ISO 2560-A

E ٧٠١٦-H٤
E 42 4 B 22 H10

Application/properties:

This electrode is suitable for producing crack-free and tough welding joints. The electrode has a stable and concentrated arc and good suitability. It is highly recommended for root pass and positional welding.

Weld metal analysis in % (typical values):

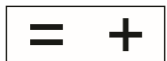
C	Mn	Si	S	P
٠,٠٦	١,٤	٠,٣٠	<٠,٠٢	<٠,٠٢

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

Heat treatment	Tensile Strength (N/mm ^٢)	Yield Strength (N/mm ^٢)	Elongation A٥ (%)	Impact energy (J) ISO-V
				-٤٥°C
AW	٥٣٠	> ٤٢٠	> ٢٢	٨٠

AW: As weld

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
٢,٥	٣٥٠	٦٠ - ٨٥
٣,٢٥	٣٥٠	٨٠ - ١٢٠
٤,٠	٣٥٠ - ٤٥٠	١١٠ - ١٧٠



Materials:

DIN Standard St ٣٧-٢ to St ٤٠-٢; St ٣٧-٣ to St ٤٢-٣; St ٣٧,٠ to ST ٥٢,٠; St ٣٧,٤ to St ٥٢,٤; StE ٢١٠,٧ to StE ٣٤٠,٧; StE ٢١٠,٧ TM to StE ٣٤٠,٧ TM; St ٣٥,٨ to St ٤٥,٨; HI; HII; ١٧mn ٤; GL-A ٣٤ to GL-E ٣٤; StE ٢٥٥ to StE ٣٥٥; WStE ٢٥٥ to WStE ٣٥٥; TStE ٢٥٥ to TStE ٣٥٥; TT ST ٣٥ N; GS-٣٨; GS-٥٢

EN Standard S٢٣٥JR to E٢٣٥; S٢٣٥J٢Gr to S٣٥٥J٢Gr; P٢٣٥T١ to P٣٥٥T١; P٢٣٥T٢; P٣٥٥T٢; L٢١٠ to L٣٤٠NB; L٢٩٠MB to L٣٤٠MB; P٢٣٥G١TH; P٣٥٥G١TH; P٢٣٥GH; P٣٤٥GH; P٢٩٥GH; S٣٥٥G١S to S٣٥٥G٣S; S٢٥٥N to S٣٥٥N; P٢٥٥NH to P٣٥٥NH; S٢٥٥NL to S٣٥٥NL.

ASTM Standard A٢٧ a.A٣٤ Gr.all; A٢١٤; A٢٣٢ Gr. ١-٥; A٢٤٤ Gr. ١, ٢, ٣; A٢٨٣ Gr. A, B, C, D; A٢٨٥ Gr.A, B, C; A٢٩٩ Gr.A, B; A٣٢٨; A٣٤٤; A٥١٥ Gr.٤٠, ٤٥, ٧٠; A٥١٤ Gr.٥٥; A٥٧٠ Gr.٣٠, ٣٣, ٣٤, ٣٠, ٣٥; A٥٧٢ Gr.٣٢, ٥٠; A٤٠٤ Gr.all; A٤٠٧ Gr.٣٥; A٤٥٤ Gr.٥٠, ٤٠; A٤٤٨ Gr.A, B; A٩٠٧ Gr.٣٠, ٣٣, ٣٤, ٣٠; A٨٤١; A٨٥١ Gr.١, ٢; A٩٣٥ Gr.٣٥; A٩٣٤ Gr.٥٠. API ٥ L Gr. B, X٣٢-X٥٤
API ٥ L Gr. B, X٣٢ - X٥٤

Remarks:

- Just Consume Dry Electrode
- Rebaking: required on ٣٠٠°C to ٣٥٠°C for ٢ hours.