



# AMA 1017N

AWS/ASME SFA-5.5  
EN ISO 2560-A

E 7016-G-H4  
E 42 6 Z B 22

## 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, filling pass and positional welding.

## Weld metal analysis in % (typical values):

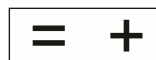
| C    | Mn  | Si  | Ni   | S     | P     |
|------|-----|-----|------|-------|-------|
| 0.06 | 1.5 | 0.6 | 0.45 | <0.02 | <0.02 |

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

| Heat treatment | Tensile Strength<br>(N/mm <sup>2</sup> ) | Yield Strength<br>(N/mm <sup>2</sup> ) | Elongation<br>A5 (%) | Impact energy (J)<br>ISO-V |
|----------------|------------------------------------------|----------------------------------------|----------------------|----------------------------|
|                |                                          |                                        |                      | -60°C                      |
| AW             | 620                                      | 500                                    | > 22                 | 55                         |
| AW: As weld    |                                          |                                        |                      |                            |

## Welding Parameters

| Diameter (mm) | Length (mm) | Amperage (A) |
|---------------|-------------|--------------|
| 2.5           | 350         | 60 - 85      |
| 3.25          | 350         | 80 - 120     |
| 4.0           | 350 - 450   | 110 - 170    |



## Remarks:

- Just Consume Dry Electrode
- Rebaking: required on 300°C to 350°C for 2 hours.