



AMA 1018N

AWS/ASME SFA-5.5
EN ISO 2560-A

E 7016-G-H4
E 46 6 Mn1Ni 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):

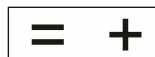
C	Mn	Si	Ni	S	P
0.06	1.45	0.5	0.9	<0.02	<0.02

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

Heat treatment	Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation A5 (%)	Impact energy (J) ISO-V
				-60°C
AW	650	510	> 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.