



AMA 1464JA

AWS/ASME SFA-5.4 **E 309 L-16**
Comparable No. of material **1.4332**
DIN 8556 **E 23 2 L R 26**
prEN 1600 **E 23 12 L R 12**

Application/properties:

This electrode is used for joining of dissimilar steels, (austenitic steels to ferritic steels) and for depositing claddings austenitic. Weld metal consists of with approximately 15% delta-ferrite. Claddings on alloyed or low-alloyed steel are already corrosion resistant in the first layer. Highest operating temperature for dissimilar steel joints is +300°C at higher temperature AMA 1604G electrode shall be used. Fine droplet metal transfer, good wash-in of joint sides, finely-rippled bead surface, easily removable slag, easy arc striking and restriking are some properties of this electrode.

Weld metal analysis in % (typical values):

C	Mn	Si	Cr	Ni
0.025	0.70	0.9	24	13

Mechanical Properties of all-weld metal:

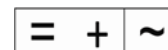
(single values are typical values)

Tensile Strength (N/mm ²)	Yield Strength 0.2% (N/mm ²)	Elongation A5 (%)	Impact energy(j) ISO - V +20°C
600	400	30	60

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
2.5	250	60 - 90
3.25	350	90 - 120
4.0	350	100 - 160
5.0	350	140 - 210



OCV>70V



Materials:

DIN EN Standard 1.4406 X2CrNiMoN 17 12 2; 1.4401 X5CrNiMo 17 12 2; 1.4404 X2CrNiMo 17 13 2 G-X2CrNiMoN 18 10; 1.4311 X2CrNiN 18 10

Other Standard ASTM/ACI A240/A312/A351: (TP)304LN; (TP)304L; CF-3; (TP)304

Rebaking: required at 350°C to 400°C for 2 hours.