AMA ١٤٦٤JB

AWS/ASME SFA-٥,٤	**E ٣٠٩ MoL-١٦**
Comparable No.of material	١,٤٤٥٩
DIN ٨٥٥٦	**E ٢٣ ١٣ ٢ L R ٢٦**
prEN ١٦٠٠	**E ٢٣ ١٢ ٢ L R ١٢**

Application/properties:
This electrode is suitable for joining of dissimilar steels, (austenitic steels to ferritic steels) and for depositing claddings austenitic. Weld metal consists of with approximately ١٥٪ 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 +٣٠٠°C; at higher temperature AMA ١٦٠٤G 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	Mo
٠,٠٢٥	٠,٩	٠,٧	٢٢,٥	١٣,٥	٢,٦

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

Tensile Strength (N/mm²)	Yield Strength ٠,٢٪ (N/mm²)	Elongation A٥ (%)	Impact energy(j) ISO - V
			+٢٠°C
٦٤٠	٤٢٠	٣٠	٥٠

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
٢,٥	٢٥٠	٦٠ - ٩٠
٣,٢٥	٣٠٠ - ٣٥٠	٩٠ - ١٢٠
٤,٠	٣٥٠	١٠٠ - ١٦٠
٥,٠	٣٥٠	١٤٠ - ٢١٠

OCV>٧٠V

= + ~

Materials:

DIN EN Standard	١.٤٤٠١ X٥CrNiMo ١٧ ١٢ ٢; ١.٤٤٠٤ X٢CrNiMo ١٧ ١٣ ٢; ١.٤٤٢٩ X٢CrNiMoN ١٧ ١٣ ٣; ١.٤٤٠٦ X٢CrNiMoN ١٧ ١٢ ٢; ١.٤٤٠٨ G-X٦CrNiMo ١٨ ١٠; ١.٤٤٣٦ X٥CrNiMo ١٧ ١٣ ٣; ١.٤٥٨١ G-X٥CrNiMoNb ١٨ ١٠; ١.٤٤٣٥ X٢rCrNiMo ١٨ ١٤ ٣; ١.٤٤٣٦ X٥CrNiMo ١٧ ١٣ ٣; ١.٤٥٧١ X٦CrNiMoTi ١٧ ١٢ ٢; ١.٤٥٧٣ X١٠CrNiMoTi ١٨ ١٢; ١.٤٥٨٠ X٦CrNiMoNb ١٧ ١٢ ٢ G-X١٠CrNiMoNb ١٨ ١٠
Other Standard	ASTM/ACI A٢٤٠/A٣١٢/A٣٥١: (TP)٣١٦L; CF-٣M; (TP)٣١٦L; (TP)٣١٦LN; (TP)٣١٦; ٣١٦Ti; ٣١٦Ti; ٣١٦Cb

Rebaking: required at ٣٥٠°C to ٤٠٠°C for ٢ hours.