

# **Electrodes with High Metal Recovery**





# AMA 1118 K

**Standards:** EN 499 E 380 RR 53  
DIN 1913 E 51 22 RR 11 160  
AWS/ASME SFA - 5.1 E 7024

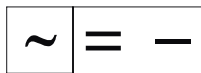
**Application / Properties:** High-efficiency electrode having a weld metal recovery of approx 155%. It is suited for welding long fillet welds of small throat thickness. Easy arc striking and restriking. Smooth welds blending into base metal without undercut. Slag partly self-releasing.

### Weld metal analysis in % (typical)

C	Mn	Si
0.08	0.4	0.8

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

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	ISO-V Impact energy (J) + 20 °C
>380	470-600	>22	100



Amperage:		
3.25 Ø	4.0Ø	5.0Ø
140-160	180-230	260-340



### Material:

Unalloyed Structural steels-----St 33 to St 52-3  
Boiler plates-----H I, H II, 17 Mn 4  
Fine grain structural steels-----StE 255 to StE 355  
Shipbuilding steels-----A, B, D, C  
cast steels-----GS-38 to Gs-52

Approval: LRS

Redrying : If necessary 1 h at 100-120°C.



# AMA 1617 K

**Standards:** EN 499                      E 38 5 B 73 H10  
 DIN 1913                                E 51 54 B (R) 12 160  
 AWS/ASME SFA - 5.1                E 7028 - H8

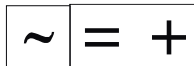
**Application / Properties:** High-efficiency electrode having a weld metal recovery of approx 165%.preferably used for welding fillets. Weld metal is crack- free and very tough. Smooth and clean welds blending into base metal without undercut. Suitable for welding primer painted component. Slag is easily removable. Welds are of X-ray quality.

**Weld metal analysis in % (typical)**

C	Mn	Si
0.08	0.55	1.15

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

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	ISO-V Impact energy (j)	
			+ 20 °C	- 30 °C
>380	470-600	>22	150	80



Amperage:		
3.25 Ø	4.0Ø	5.0Ø
130-170	160-220	220-320



**Material:**

Unalloyed Structural steels-----St 33 to St 52-3  
 Boiler plates-----H I, H II, 17 Mn 4  
 Fine grain structural steels-----StE 255 to StE  
 355, WStE 255 to WStE 355  
 Shipbuilding steels-----A, B, D, E, AH 32 to EH 36

Redrying : Required at 300 to 350°C for 2 hrs.