

Armoid 1



An austenitic electrode designed for welding high tensile steels, including armour plate, and for joining stainless steel to mild and low alloy steels.

Classifications:	EN 1600:E 20 10 3 R
Approvals:	MVEE 1050: 1A, 1B

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+, AC
Ferrite Content:	10 - 25
Alloy Type:	Austenitic CrNiMoMn
Coating Type:	Rutile

Typical Tensile Properties		
Condition	Tensile Strength	Elongation
ISO		
As welded	690 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As welded	-20 °C	45 J

Deposition Data						
Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300 mm	60-80 A	25 V	0.57 kg	93	50 sec	0.8 kg/h
3.2 x 300 mm	80-110 A	21 V	0.59 kg	60	51 sec	1.2 kg/h
4.0 x 350 mm	90-160 A	23 V	0.63 kg	33	63 sec	1.7 kg/h
5.0 x 350 mm	140-205 A	-	-	-	-	-