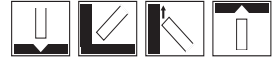


Armoid 1

EN 1600 E 20 10 3R



Description and applications

Armoid 1 is a rutile-coated stainless steel electrode specially designed for welding hardenable high tensile strength steels, and for dissimilar steel welding. Armoid 1 was originally developed for welding armour plate.

Approvals

MOD: MVEE 1050: 1A, 1B

Alloy Type: Austenitic CrNiMoMn

Coatin Type: Rutile

Ferrite Content: 10-25

All-weld metal properties

Chemical Composition

All weld metal %

	Min	Max
C		0.10
Si	0.30	1.00
Mn	0.80	1.50
S		0.030
P		0.020
Cr	19.0	21.0
Ni	9.0	11.0
Mo	2.5	3.5
Cu		0.50

Mechanical Properties of Weld Metal

All Weld Metal

ISO

As Welded

Properties	Min	Typ
Rm (MPa)	620	690
A5 (%)	20	28
Charpy V at -20°C (J)		45

Current range

AC (min OCV 65) or DC +

Size (mm)	2.5	3.2	4.0
Current (amps)	60-80	80-110	90-160