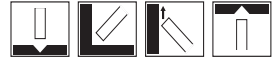


Manual Metal Arc Electrodes

Low Alloy MMA Electrodes

Fortrex NQ1

AWS A/SFA 5.5-81 E9016G



Description and applications

Fortrex NQ1 is a basic, thinly coated electrode designed to weld HY80 and equivalent grade steels in all positions except vertical down. This was the first electrode to gain MOD(N) NES 769 approval for the welding of Q1(N) steel. Also suitable for welding RQT 501 steel.

Approvals

MOD (Navy): Q1N

DEFSTAN 02-769 Q1(N)

All-weld metal properties

Chemical Composition

All weld metal %

	Min	Max
C		0.07
Si	0.20	0.60
Mn	1.30	1.70
S		0.02
P		0.02
Cr		0.05
Ni	0.60	1.30
Mo	0.10	0.60
V		0.01
Cu		0.05
Al		0.025
Ti		0.04

Mechanical

YS
UTS
Elongation

Charpy V impact values at -50°C

As-welded

600 min N/mm²
620 min N/mm²
20 min %
50 min ave J

Current range AC (min OCV 55) or DC +/- (DC Preferred)

Size (mm)	3.2	4.0	5.0
Current (amps)	70-140	110-180	160-250