

AI-0150

Specifications

AS/NZS 4855-B - E49 16-A U H10

AWS/ASME A5.1 : E7016 H8

Description and Applications

A high strength, low hydrogen electrode developed especially for the maintenance welding industry. Used for welding of joints subject to high stress or restraint. Features include a double coating to reduce the susceptibility of moisture pick-up and the ability to weld with very low amperages. Also, easily form double beads in all positions welding with a short arc. Very good X-ray properties.

Suitable for joining and surfacing in mechanical engineering, boilermaking and plant fabrication using high tensile steels and cast steels as well as fine grained structural steel with tensile strengths of 440-690 MPa (63,000-100,000 psi).

AI-0150 is distinguished by easy weldability. It's easy running characteristic make it ideal for poorly fitted joints, insufficient weld preparation and hard to reach areas. This is further facilitated by it being a contact electrode. The weld metal is not affected by steel impurities making it ideal as a maintenance electrode.

AI-0150 can be used on AC or DC settings.

Typical Weldmetal Analysis

C	Mn	Si	Fe
0.06	0.9	0.7	Bal

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	550MPa
Yield Strength (0.2%)	450Mpa
Elongation in 50mm	28%
Charpy Impact	100J (20°C)

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	8
3.25	DC /AC	120
4.0	DC /AC	140
5.0	DC /AC	170



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Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4F) Horizontal overhead position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up, (3G, 3F, 5G down) Vertical position down

Disclaimer

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