

## Fortrex NQ1

A basic coated all positional low hydrogen electrode specifically designed for welding HY80 and equivalent steels giving low temperature impact properties.

Specifications	
Classifications	SFA/AWS A5.5 : E9016-G
Approvals	MoD : Def Stan 02-769 Q1(N)

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

Welding Current	AC, DC-
Alloy Type	C,Mn,0.8%Ni,0.3%Mo
Coating Type	Basic covering

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	70-140 A	24.4 V	62 %	72.9 sec	1.25 kg/h
4.0 x 450.0 mm	110-180 A	23.3 V	64 %	80 sec	1.73 kg/h
5.0 x 450.0 mm	160-250 A	23.3 V	66 %	90 sec	2.33 kg/h