

## 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.

| Specifications  |                                                         |
|-----------------|---------------------------------------------------------|
| Classifications | EN ISO 3581-A : E 20 10 3 R                             |
| Approvals       | CE : EN 13479<br>UKCA : EN 13479<br>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 Charpy V-Notch Properties |                     |              |
|-----------------------------------|---------------------|--------------|
| Condition                         | Testing Temperature | Impact Value |
| ISO                               |                     |              |
| As Welded                         | -20 °C              | 45 J         |

| Deposition Data |           |         |                |                                        |                 |
|-----------------|-----------|---------|----------------|----------------------------------------|-----------------|
| Diameter        | Current   | Voltage | Efficiency (%) | Fusion time per electrode at 90% I max | Deposition Rate |
| 2.5 x 300.0 mm  | 60-80 A   | 25 V    | 57 %           | 50 sec                                 | 0.8 kg/h        |
| 3.2 x 300.0 mm  | 80-110 A  | 21 V    | 59 %           | 51 sec                                 | 1.2 kg/h        |
| 4.0 x 350.0 mm  | 90-160 A  | 23 V    | 63 %           | 63 sec                                 | 1.7 kg/h        |
| 5.0 x 350.0 mm  | 140-205 A |         |                |                                        | 0.0 kg/h        |