

ESAB ARMOID 1

ESAB ARMOID 1 is a stainless steel electrode designed for welding of armour plates and crack sensitive steels.

| | |
|------------------------|---------------------|
| Welding Current | AC, DC+ |
| Alloy Type | Austenitic Cr-Ni-Mo |
| Coating Type | Rutile |

| Typical Tensile Properties | | | |
|----------------------------|-----------------------|------------------|------------|
| Condition | Conditional Statement | Tensile Strength | Elongation |
| AWS | | | |
| As Welded | As welded | 730 MPa | 35 % |

| Typical Weld Metal Analysis % | | | | | |
|-------------------------------|------|------|------|-------|------|
| C | Mn | Si | Ni | Cr | Mo |
| 0.08 | 1.40 | 0.50 | 8.50 | 19.50 | 2.80 |

| Deposition Data | |
|-----------------|-----------|
| Diameter | Current |
| 0.0 x 350.0 mm | 80-120 A |
| 0.0 x 350.0 mm | 120-170 A |