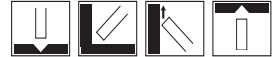


### Armoid 1

EN 1600 E 20 10 3R



#### Description and applications

Armoid 1 is a rutile-coated stainless steel electrode specially designed for welding hardenable high tensile strength steels, and for dissimilar steel welding. Armoid 1 was originally developed for welding armour plate.

#### Approvals

MOD: MVEE 1050: 1A, 1B

Alloy Type: Austenitic CrNiMoMn

Coatin Type: Rutile

Ferrite Content: 10-25

#### All-weld metal properties

Chemical Composition

All weld metal %

	Min	Max
C		0.10
Si	0.30	1.00
Mn	0.80	1.50
S		0.030
P		0.020
Cr	19.0	21.0
Ni	9.0	11.0
Mo	2.5	3.5
Cu		0.50

#### Mechanical Properties of Weld Metal

All Weld Metal

ISO

As Welded

Properties	Min	Typ
Rm (MPa)	620	690
A5 (%)	20	28
Charpy V at -20°C (J)		45

#### Current range

AC (min OCV 65) or DC +

Size (mm)	2.5	3.2	4.0
Current (amps)	60-80	80-110	90-160