



AMTEC 275 HIGH STENGTH LOW ALLOY STEEL AC/DC REVERSE ELECTRODE

General Characteristics

Amtec 275 is an all position, controlled hydrogen electrode that has high strength, outstanding elongation and ductility for an electrode of this type, that will provide crack free welds under high stress conditions. This electrode is smooth running on both AC and DC currents, shows little spatter, and has a self-releasing slag and a uniform rippled deposit. Welds are easily machined. This electrode also exhibits extra low moisture content of below .14%.

Procedure

Clean the weld area. Maintain a short arc gap, and use a stringer or slight weave technique. Chip slag between passes to ensure dense welds without slag inclusions. For the majority of materials to be welded with these electrodes, minimum preheats between 212°F (100°C) and 392°F (200°C) are required to avoid hydrogen induced “cold” cracking. Can be used in the Flat, Vertical up, Vertical down, Horizontal and Overhead positions.

Application

Amtec 275 is used for structural and repair welds on high strength fine grained steels. It is recommended for the welding of low alloy, high strength steels, such as T-1, Hy-80, Hy-90, Hy-100, SSS-100, and Jallooy 90 and 100. It is commonly used to fabricate tanks, containers, covers, and high strength pipe. It is also recommended for welding low alloy steels containing nickel, manganese, molybdenum, and chromium, such as I-beams and other superstructures.

Tensile Strength	120,000 PSI
Yield Strength	96,000 PSI
Elongation	23%
Impact Strength	50 J: -51°C

Diameter (Inch)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

Amps (approx.)	65-100	100-140	140-190	190-250
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CONFIDENTIAL INFORMATION
Subject to change without notice

Tip Color – Plain
275 Imprint