

# AMERIARC

## Ameri Super

### INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.1 E 7018-1  
DIN 1913: E51 54B R 10

EN 499: E 42 4 B 12 H5  
ISO 2560: E51 5B120 26H

### DESCRIPTION & APPLICATION:

**Ameri Super** is the universal low hydrogen electrode for all welding positions. It is moisture resistant steel electrode for unalloyed construction steels. The electrodes have a smooth running arc, leaving little or no residual spatter and easy slag detachability resulting in clean even beads of excellent radiographic standard.

A wide range of application for welding Shipbuilding, Pressure vessel & Boiler Industry.

### WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	Mn	Si	S	P	Mo	Fe
.04	.90	.60	.013	.018	.40	Bal.

**Flux Color :** Tan/grey

### TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	84,000 psi (610 MPa)
Yield Strength	69,000 psi (500 MPa)
Elongation	32%
Impact Energy	90J: -30°C

### WELDING CURRENT & INSTRUCTIONS:

**Recommended Current :** DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	65	100	140
Maximum Amperage	100	140	190

### PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
	Length (mm)	14" (350)	14" (350)	14" (350)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0