

Avesta P7 AC/DC

Stick electrode

Classifications

high-alloyed

EN ISO 3581-A:

E 29 9 R

Characteristics and field of use

Avesta P7 is a high-alloyed Cr-Ni electrode with approx. 40% ferrite offering high tensile strength and excellent resistance to cracking. The chemical composition corresponds to AWS A5.4 E312. Avesta P7 is primarily intended for welding dissimilar joints between stainless steel, high strength steels, tool steel, spring steel and 14% Mn-steel, as well as other difficult-to-weld combinations.

Base materials

For welding steels such as					
Outokumpu	EN	ASTM	BS	NF	SS
Specially designed for difficult-to-weld steels such as Mn-steels, tool steels and high temperature grades.					

Typical analysis of all-weld metal (Wt-%)

C	Si	Mn	Cr	Ni
0.09	0.8	0.8	29.0	9.5

Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0.2%	Tensile strength	Elongation ($L_0=5d_0$)	Impact values in J CVN
	MPa	MPa	%	+20°C:
untreated	620	810	20	25

Operating data

Polarity = + / ~

Dimensions (mm)	Amperage A
2.5	50-80
3.25	80-120
4.0	100-160
5.0	160-220