



SUPERIOR ALL-POSITION CONTROLLED-HYDROGEN ELECTRODE

AC or DC REVERSE (ELECTRODE+)

GENERAL CHARACTERISTICS:

AM 640 is a high tensile strength ferritic electrode. This high quality, all position, low amperage electrode features rapid deposition. Deposits have good ductility, are dense, crack-free and of x-ray quality. AM 640 is excellent for steels sensitive to cracking when welded with conventional mild steel electrodes. Superior impact resistance at normal and sub-zero temperatures.

APPLICATIONS:

For “tramp” and “problems” steels high in sulfur, phosphorus, or other elements added to improve the machinability of the steel. For fabrication of “H” and “I” beams, angle and channel iron, pipelines, and all other steel structures. For circular tube to plate welds, and other type joints subject to stress and strain.

TECHNICAL DATA:

Tensile Strength	up to 80,000 psi				
Current	AC or DC Reverse (Electrode+)				
Amperage	60 -100	110-150	140-200	220-280	300-375
(in)	3/32	1/8	5/32	3/16	1/4
(mm)	2.5	3.25	4.0	5.0	6.0

PROCEDURE:

Area to be welded should be cleaned thoroughly. Surface contamination must be removed and bevel or chamfer where required. Maintain close arc length. Vertical joints should be welded from bottom up, using rapid weave technique. Do not whip. Use drag technique to make horizontal fillet welds. Slag is easily removed.

Manufactured by **AmAlloy Industries®**
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www.amalloy.com