

CLASIFICARE / STANDARDS

AWS A5.1: E 6013
 EN ISO 2560-A: E 38 0 R 12

AUTORIZARI / APPROVALS

LRS: 2Y H15 BV: 2HH
 TÜV: E 42 0 R 12 GL: 2Y H15
 DB: N° 10.037.03 DNV: 2
 ANR: 2H ABS: 2

CARACTERISTICI PRINCIPALE

Electrozi cu invelis rutilic de grosime medie, recomandati in special pentru sudarea constructiilor metalice usoare, tablelor subtiri din otel carbon. Sunt indicati pentru sudarea otelurilor nealiate cu continut de carbon de maxim 0,25%, pentru structuri usoare, utilizate pentru temperaturi pana la 0°C, ca de exemplu:

- OL 37.3; OL 44.2; OL 44.3 - STAS 500/2
- OLT 35 - STAS 8183
- S185, S235, S275, S355 - EN 10025
- P235, P265, P295, P 335 - EN 10028-2

Amorsare si reamorsare usoara. Arcul este stabil, stropirea este foarte redusa atat in curent continuu cat si in curent alternativ. Aspect estetic al cordonului. Buna detasabilitate a zgurii.

MAIN FEATURES

Rutile medium coated electrode, especially developed for welding mild steels for light metallic constructions and thin sheets. Suitable for use in structural engineering, shipbuilding and vehicle, made of steels with max. 0.25%, for a service temperature up to 0°C, like:

- OL 37.3; OL 44.2; OL 44.3 - STAS 500/2
- OLT 35 - STAS 8183
- S185, S235, S275, S355 - EN 10025
- P235, P265, P295, P 335 - EN 10028-2

Excellent striking and restriking qualities. The electrode welds with a stable arc and very spattering loss. The slag is self-releasing.

DOMENII DE APLICATIE

Constructii metalice

MAIN APPLICATIONS

Metal working industry

POZITII DE SUDARE / WELDING POSITIONS


1G PA 2F PB 2G PC 3G PF 4G PE 5G PF AWS EN

CURRENT / CURRENT: DC-, AC

Tensiune de mers in gol = min. 50V /
 Minimum 50 V open circuit voltage

ANALIZA CHIMICA A METALULUI DEPUS % / ALL - WELD METAL CHEMICAL ANALYSIS %

C	Mn	Si	S	P				
0.06 - 0.10	0.30 - 0.60	0.20 - 0.50	max. 0.03	max. 0.03				

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

Limita de curgere/Yield strenght N/mm ²	Rezistenta la rupere/Tensile strenght N/mm ²	Alungirea/Elongation A _{5d} %	Kv J 0°C
430 - 470	490 - 600	min. 24	min. 47

DEPOZITARE - CALCINARE

A se pastra in locuri uscate la temperatura camerei.

STORAGE - REBAKING

Keep dry and store at room temperature.

CURENTI DE SUDARE / AMPERAGE

1.60	2.00	2.50	3.20	4.0	5.0			
30 - 50	40 - 60	60 - 90	110 - 135	160 - 180	180 - 210			

AMBALARE / PACKING

Diametru	mm	1.60	2.00	2.50	2.50	3.20	3.20	4.0	4.0	5.0
Lungime / Length	mm	250	300	300	350	350	450	350	450	450
Greutate pe electrod / Weight per electrode	g	5.90	11.80	16.00	19.50	31.95	41.80	48.10	64.50	97.20
Nr de fire pe pachet / Pcs. per innerbox	n°	591	323	237	230	139	13	92	92	60
Greutate pachet / Weight per innerbox	kg	3.5	3.8	3.8	4.5	4.5	5.8	4.5	5.8	6.0
Nr de fire pe cutie / Pcs. per outerbox	n°	2364	1292	948	690	418	418	276	276	180
Greutate pe cutie / Weight per outerbox	kg	14.0	11.4	11.4	13.5	13.5	17.4	13.5	17.4	18.0
Cod / Code		W0002 88257	W0002 88258	W0002 88259	W0002 88260	W0002 88261	W0002 88262	W0002 88263	W0002 88264	W0002 88265