

ALTIG 308 L

BAGHETE TIG / GTAW TOD



CLASIFICARE / STANDARDS

AWS A5.9-93: ER 308 L
EN ISO 14343-A: W 199 L

AUTORIZARI / APPROVALS

DB (43.098.06)

CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor inoxidabile austenitice cu compozitie chimica similara, in mod deosebit pentru oteluri de tipul 304 si 304 L. Continutul scazut de carbon permite obtinerea de suduri cu rezistenta marita la corozie intergranulara. Poate fi utilizat si pentru sudarea otelurilor stabilizate (AISI 321 - AISI 347) cu temperaturi de lucru inferioare la 400°C.

MAIN FEATURES

Tig rod for austenitic stainless steel welding with similar chemical composition, in particular type AISI 304 and 304 L. Low carbon reduces the possibility of intergranular corrosion. It may be used for welding stabilized steels (e.g. AISI 321 - AISI 347) with working temperatures not exceeding 400°C.

DOMENII DE APLICATIE

Constructii metalice;
Productia de automobile si electrocasnice;
Cazangerie inclusiv in ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including the chemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



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

CURRENT / CURRENT: DC-

GAZ / GAS: Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ROD CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
≤ 0.03	1.00 - 2.50	0.30 - 0.60	≤ 0.03	≤ 0.03	19.5 - 22.0	9.0 - 11.0	≤ 0.75	≤ 0.75

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C	Kv J -196°C
Ar	Stare sudată/As welded	≥ 580	≥ 420	≥ 35	≥ 200	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm x lungime mm / Diameter mm x length mm					
		1.2 x 1000	1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000	
Tub/Tube	5 kg	W000283419	W000283420	W000283421	W000283422	W000283423	

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.