

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 309 L
EN ISO 14343-A: W 23 12 L

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Baghete TIG pentru sudarea otelurilor inoxidabile cu compozitie chimica similara si pentru sudarea imbinarilor eterogene dintre oteluri carbon si oteluri inoxidabile. Continutul scazut de carbon permite obtinerea de suduri rezistente la coroziune intergranulara. Pot fi utilizate pentru depuneri de straturi tampon inainte de depunerea straturilor tip 304 sau 304L.

MAIN FEATURES

TIG rod for welding of austenitic stainless steel of similar composition and for different material welding with difficult weldability like carbon steel with stainless steel. The low carbon content allows to obtain welding resistant to intergranular corrosion. It can be used as buffer layer on carbon steel before welding with stainless steels type 304 and 304 L.

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

CURRENT / CURRENT: DC-

GAZ / GAS: Ar (11) 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 - 0.65	≤ 0.03	≤ 0.03	23.0 - 25.0	12.0 - 14.0	≤ 0.75	≤ 0.75

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J +20°C
Ar	Stare sudată/As welded	≥ 520	≥ 420	≥ 35	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm x lungime mm / Diameter mm x length mm					
		1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000		
Tub/Tube	5 kg	W000283480	W000283481	W000283482	W000283483		

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