

ALTIG 347

BAGHETE TIG / GTAW TOD



CLASIFICARE / STANDARDS

AWS A5.9-93: ER 347
EN ISO 14343-A: W 199 Nb

AUTORIZARI / APPROVALS

DB: 43.116.03

CARACTERISTICI PRINCIPALE

Baghete TIG cu compozitie chimica 20 Cr - 10 Ni stabilizate cu niobiu. Corespunzatoare pentru sudarea otelurilor inoxidabile stabilizate cu titan sau niobiu, tip AISI 347 si AISI 321. Continutul de Nb creste rezistenta la coroziune intergranulara. Poate fi folosita pentru aplicatii la temperaturi ce depasesc 400°C.

MAIN FEATURES

TIG rod with 20 Cr-10 Ni content, niobium stabilized. Suitable for stainless steels titanium or niobium stabilized, like AISI 347 and AISI 321 The Nb content increase the resistance to the intergranular corrosion. Fit for welding with temperature exceeding 400°C.

DOMENII DE APLICATIE

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

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for 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	Nb
≤ 0.08	1.00 - 2.50	0.30 - 0.65	≤ 0.03	≤ 0.03	12.5 - 19.0	9.0 - 11.0	≤ 0.75	≤ 0.75	10x%C±1%

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
Ar	Stare sudată/As welded	≥ 550	≥ 400	≥ 30	≥ 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	W000283438	W000283439	W000283440	W000283441		

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