

CLASIFICARE / STANDARDS

AWS A5.28-93:	ER 70S-A1	
EN ISO 21952-A:	W Mo Si	
EN 1668-97:	W2 Mo	

AUTORIZARI / APPROVALS
CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor slab aliate cu 0,5% Mo cu limita de curgere ridicata si rezistente la temperaturi ridicate.
Destinate sudarii straturilor de radacina la tevi, fara utilizarea unei perne de gaz.

MAIN FEATURES

Tig rod for low alloy high tensile steels and creep resistant steels of the 0,5% Mo type.
Suitable for root pass on pipe welding, without backing gas.

DOMENII DE APLICATIE

Cazangerie;
Industria chimica si petrochimica;
Sudarea tevilor.

MAIN APPLICATIONS

Vessels, boilers fabrication;
Chemical, petrochemical 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 (11) EN 439

ANALIZA CHIMICA A BAGHETEI % / ROD CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Mo				
0.08 - 0.12	0.70 - 1.30	0.50 - 0.70	≤ 0.020	≤ 0.020	0.40 - 0.60				

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	≥ 600	≥ 500	≥ 23	≥ 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			
Tub/Tube	5 kg	W000283357	W000283358	W000283359			

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