

CLASIFICARE / STANDARDS

AWS A5.28-96: ER 80S-Ni1
EN ISO 636-A: W 46 6 MG3Ni

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor aliate cu 1% Ni si a otelurilor cu granulatie fina destinate a lucra la temperaturi scazute. Bune caracteristici mecanice si de tenacitate.

Destinata sudarii straturilor de radacina la tevi, fara perna de gaz. Recomandat pentru sudarea otelurilor de tip A 333 - 67, A 334 - 67 si a tevilor din otelurile X 56, X 60, X 65, X 70, X 80.

MAIN FEATURES

Tig rod for low alloy 1% Ni and fine grained steels for low temperature applications welding. Good mechanical and toughness properties.

Suitable for root pass on pipe welding, without backing gas. Suitable for welding A 333 - 67, A 334 - 67 steels and pipe X 56, X 60, X 65, X 70, X 80.

DOMENII DE APLICATIE

Constructii metalice;
Cazangerie inclusiv ind. chimica/petrolifera;
Sudarea tevilor;
Tinichigerie / instalatii.

MAIN APPLICATIONS

Metal working industry;
Vessels, boilers fabrication including the chemical industry;
Pipes fabrication;
Coachbuilders.

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	Ni	Mo	S	P	Cr	V	Cu
0.06 - 0.12	1.00 - 1.25	0.50 - 0.80	0.80 - 1.10	≤ 0.15	≤ 0.020	≤ 0.020	≤ 0.15	≤ 0.03	≤ 0.35

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -60°C
Ar	Stare sudată/As welded	≥ 550	≥ 470	≥ 20	≥ 27

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	W000283396	W000283397	W000283398			

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