

**CLASIFICARE / STANDARDS**

EN ISO 17632-A: T 46 2 P C 1 H5 EN ISO 17632-B: T 55 2 T 1-1CA-UH5 AWS A5.20: E71T-1H8	<b>AUTORIZARI / APPROVALS</b> <b>ABS:</b> 3YSA H5 (P) <b>GL:</b> 4Y40H5S (P) <b>LRS:</b> 3YS H5 (P) <b>RMRS:</b> 3Y 40S HHH (P) <b>DNV:</b> IIIY40MS H5 (P) <b>DB:</b> 42.116.13 <b>BV:</b> SA3YM HH (P)
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**CARACTERISTICI PRINCIPALE**

Sarma tubulara cu flux rutilic, pentru sudarea intr-un singur strat sau in mai multe straturi a otelurilor carbon cu caracteristici de tenacitate pana la -20°C. Recomandat pentru sudarea in constructii navale, constructii feroviare si de material rulant, constructii de poduri etc. Caracterizata printr-o rata mare de depunere (ex. ptr. 245A, 27V, 10 m/min. rata de depunere este de 4,3 Kg/ora). Se poate suda in toate pozitiile. Destinata sudarii in protectie de gaz CO<sub>2</sub>.

**MAIN FEATURES**

*Rutile cored wire for welding in single or multipass technique of carbon steels with high toughness properties down to -20°C. Recommended for shipbuilding applications, rolling stock construction, and construction of bridges. High deposition rate (ex. for amperage 245, a current of 27V and a feed rate of 10 m/min., the deposition rate is 4.3 Kg/hour). Suitable for welding in all positions. To be used with CO<sub>2</sub> shielding gas.*

**DOMENII DE APLICATIE**

Constructii navale;  
 Constructii feroviare si de material rulant;  
 Masini agricole;  
 Constructii de poduri, masini de decopertat etc.

**MAIN APPLICATIONS**

*Shipbuilding;  
 Rolling stock construction;  
 Agriculture machines;  
 Bridge cranes, cranes, earth moving machines.*

**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:** CO<sub>2</sub>
**H<sub>2</sub> DIF. / DIFF. H<sub>2</sub>:** 3 ml / 100 g max

**ANALIZA CHIMICA A METALULUI DEPUȘ / ALL-WELD METAL CHEMICAL ANALYSIS %**

GAZ/GAS	C	Mn	Si	S	P			
CO <sub>2</sub>	0.05	1.20	0.35	≤ 0.025	≤ 0.020			

**CARACTERISTICI MECANICE / MECHANICAL PROPERTIES**

GAZ/GAS	Tratament termic/Heat treatment	Rm N/mm <sup>2</sup>	Rs N/mm <sup>2</sup>	E % 5d	Kv J -20°C
CO <sub>2</sub>	Stare sudată/As welded	530 - 680	≥ 460	≥ 24	≥ 50

**AMBALARE STANDARD / STANDARD PACKING**

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm					
		1.0	1.2	1.4	1.6		
B 300	16 kg		W000281686		W000281687		
S 200	5 kg		W000281684				

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