

### CLASIFICARE / STANDARDS

AWS A5.28-96: ER90S-G  
EN ISO 16834-A: G 55 2 M Mn 3 Ni Cr Mo

### AUTORIZARI / APPROVALS

DB: 42.116.28

### CARACTERISTICI PRINCIPALE

Sarma plina cuprata slab aliata cu Ni-Cr-Mn, pentru sudare in mediu de gaz protector in toate pozitiile de sudare. Se recomanda a se utiliza in amestec de gaze (Ar/CO<sub>2</sub>) dar poate fi utilizata si in mediu de CO<sub>2</sub>. Poate fi utilizata pentru sudarea otelurilor slab aliate, cu limita de curgere de 550 N/mm<sup>2</sup> si cu o rezistenta la rupere de 750 N/mm<sup>2</sup> (tip T1, N.A.ETRA, VELDOX sau similare). Poate fi utilizata si cand sunt necesare inalte caracteristici de tenacitate la temperaturi scazute. Pentru a fi obtinute cele mai bune rezultate se recomanda sudarea cu o energie liniara cat mai mica.

### MAIN FEATURES

Copper coated low alloy wire with Ni-Cr-Mn, for GMAW welding in all positions. To be used preferably with Ar/CO<sub>2</sub> shielding gas, but it can be used with CO<sub>2</sub> too. Suitable for single pass or multipass welding of low alloy steels, with minimum yield strength of 550 N/mm<sup>2</sup> and with tensile strength up to 750 N/mm<sup>2</sup> (type T1, N.A.ETRA, VELDOX and similar). It can be used also when good toughness characteristic in low temperature are required. To obtain the best result, the use with low heat input is advised. Good extetical bead and low spatters.

### DOMENII DE APLICATIE

Constructii navale, boilere (inclusiv cele din industria petrochimica);  
Industria constructoare de masini;  
Constructii metalice.

### MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry);  
Industrial machinery construction;  
Metal working industry.

### 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 / CO<sub>2</sub>-CO<sub>2</sub>  
(M2) (C1) EN 439

### ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	
≤ 0.12	1.30 - 1.80	0.60 - 0.80	≤ 0.018	≤ 0.015	0.50 - 0.60	0.40 - 0.60	0.15 - 0.30	0.30	

### CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm <sup>2</sup>	Rs N/mm <sup>2</sup>	E % 5d	Kv J -40°C
Ar/CO <sub>2</sub> (M21)	Stare sudată/As welded	650 - 750	≥ 600	≥ 16	≥ 50

### AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm					
		1.0	1.2	1.6	2.0		
B 300/SS	16 kg	W000282917	W000282919				
Drum	300 kg	W000282918	W000282920				

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