

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 309 L Si
EN ISO 14343-A: G 23 12 L Si

AUTORIZARI / APPROVALS
CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea MIG in toate pozitiile a otelurilor inoxidabile austenitice cu compozitie chimica similara si pentru sudarea materialelor disimilare sau dificil sudabile, ca imbinarile intre oteluri carbon si otelurile inoxidabile. Continutul scazut de carbon conduce la cresterea rezistentei la coroziune intergranulara. Poate fi utilizata si pentru realizarea straturilor tampon pe otelurile carbon inainte de a suda cu tipul AISI 304 sau 304L. Continutul ridicat de siliciu imbunatateste stabilitatea arcului si sudabilitatea. Aceasta conduce la obtinerea unor suduri cu aspect regulat, dar mai ales reduce pericolul aparitiei stropilor si porozitatii atunci cand se foloseste transferul de tip short-arc.

MAIN FEATURES

Solid wire for MIG welding, in all positions, of austenitic stainless steel of similar composition and for different welding materials with difficult saldability like carbon steel with stainless steel. The low carbon content increases resistance to intergranular corrosion. It can be used as buffer layer on carbon steel before welding with stainless steels type 304 and 304 L. The higher silicon content improves the arc stability and weldability. This gives a good attractive bead and, especially in short-arc transfers, reduces porosity and spatters.

DOMENII DE APLICATIE

Industria constructoare de masini;
Industria de automobile si electrocasnice;
Cazangerie inclusiv ind. chimica/petrolifera;
Fabricarea tevelor.

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 PA 2F PB 2G PC 3G PF 3G PG 4G PE 5G PF 5G PG AWS EN

CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
≤ 0.03	1.20 - 2.50	0.65 - 1.00	≤ 0.03	≤ 0.03	23.0 - 25.0	12.0 - 14.0	≤ 0.75	≤ 0.75

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
MIX	Stare sudată/As welded	≥ 580	≥ 420	≥ 30	≥ 27

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm					
		0.8	1.0	1.2			
BS 300	15 kg	W000283096	W000283097	W000283098			

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