

CLASIFICARE / STANDARDS

EN ISO 17632-A: T 46 2 P C 1 H5	ABS: 3Y400SA H5	RINA: 3Y40S H5
EN ISO 17632-B: T 55 2 T 1-1CA-UH5	LRS: 3Y40S H5	TÜV: T46 2 P C 1 H5
AWS A5.20: E71T-1H4	DNV: IIIY40S H5	DB: N°42.047.08
	GL: 3Y40S H5	
	BV: SA3Y40M H5	

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma tubulara cuprata pentru sudarea intr-un singur strat sau in mai multe straturi. Randamentul de depunere este ridicat, fara stropi si cu un aspect al cordonului regulat chiar si pe table cu calamina. Recomandat in mod deosebit pentru utilizarea in constructii navale, in special in pozitia vertical ascendent, permitand realizarea unor cordoane de mici dimensiuni. Se poate suda folosind CO₂ de mare puritate. Este recomandat pentru sudarea otelurilor carbon de tipul Fe430 - Fe510, cu bune caracteristici de tenacitate pana la -20°C.

MAIN FEATURES

Rutile seamless copper coated cored wire, for welding metal constructions in single or multipass technique. Designed for high deposition rate welding, stable and low spattering arc characteristics. Easy slag removal and good bead appearance, even on oxidized plates. Particularly designed for shipbuilding applications, especially for vertical up welding, even without waving the torch in order to obtain small size beads. Shielding gas: CO₂. For welding carbon manganese steels like Fe 430 - Fe 510, with good impact properties down to -20°C.

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: CO₂

H₂ DIF. / DIFF. H₂: 3 ml / 100 g max

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

GAZ/GAS	C	Mn	Si	S	P			
CO ₂	0.03 - 0.07	1.20 - 1.60	0.35 - 0.70	≤ 0.020	≤ 0.020			

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ/GAS	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -20°C
CO ₂	Stare sudată/As welded	530 - 640	≥ 460	≥ 24	≥ 80

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm					
		1.0	1.2	1.4	1.6		
B 300	16 kg		W000281671	W000281673	W000281674		
B 200	5 kg	W000281669	W000281670				
Drum	200 kg		W000281672				

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