

CLASIFICARE / STANDARDS

EN ISO 2560-A: E 50 6 Mn1 Ni1 B 42 H5
AWS A5.5: E 8018-G

AUTORIZARI / APPROVALS

TÜV: approved GL: 4Y 42 H5
DB: N° 10.116.16 BV: 5Y HHH
ANR: 4Y 46 HHH

CARACTERISTICI PRINCIPALE

Electrozi bazici cu invelis gros destinati in special la structurile sudate puternic solicitate dinamic din oteluri cu limita de curgere ridicata, exploatare la temperaturi pana la -60°C. Se recomanda pentru oteluri ca:

- OL 60 - STAS 500/2
- OCS 55.5a; OCS 58.5a - STAS 9021
- K 52.7a - STAS 2883/3
- S275; S355 - EN 10025
- L290; L360; L415; L445 - EN 10028-2

Arcul arde stabil. Bun aspect al cordonului cu stropire redusa. Zgura acopera bine randul de sudura, iar dupa solidificare se desprinde usor. Continutul de hidrogen difuzibil: max. 5 cm³/100g M.D. Randalmentul nominal efectiv: RE = 113%.

DOMENII DE APLICATIE

Industria constructoare de masini. Constructii civile si feroviare. Platforme marine, recipienti sub presiune.

MAIN FEATURES

It is a heavy covered nickel alloy basic electrode designed for welding fine grained structural steels, with high yield strength, used at below-zero temperature down to -60°C. Nibaz 65 deposits a metal with high toughness at low temperature and also with low content of diffusible hydrogen. It is intended to be used for:

- OL 60 - STAS 500/2
- OCS 55.5a; OCS 58.5a - STAS 9021
- K 52.7a - STAS 2883/3
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It welds with a stable arc; the slag is easy to remove. The diffusible hydrogen content of weld metal places the electrode in class A, very low hydrogen content - max. 5 cm³/100g weld metal. Weld metal recovery: RE = 113%.

MAIN APPLICATIONS

Industrial machinery construction. Metal working industry. Off-shore plants, vessels, boilers fabrication.

POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 4G 5G AWS
PA PB PC PF PE PF EN

CURRENT / CURRENT: DC+, AC

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

C	Mn	Si	S	P	Ni				
0.06 - 0.10	1.40 - 2.00	0.30 - 0.60	≤ 0.015	≤ 0.020	0.70 - 1.20				

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -60°C
Stare sudată/As welded	600 - 720	≥ 500	≥ 22	≥ 47
Dupa/after 620°C x 1h	550 - 720	≥ 460	≥ 20	≥ 47

DEPOZITARE - CALCINARE

A se pastra in locuri uscate la temperatura camerei. Inainte de sudare electrozii se vor usca in mod obligatoriu timp de 2 h la 250 ÷ 300°C.

STORAGE - REBAKING

Keep dry and store at room temperature. Rebaking: 2 h min. at 250 - 300°C.

CURENTI DE SUDARE / AMPERAGE

2.50	3.20	4.00	5.00					
65 - 90	130 - 150	160 - 190	200 - 250					

AMBALARE / PACKING

Diametru	mm	2.50	3.20	4.00	4.00	5.00		
Lungime / Length	mm	350	350	350	450	450		
Greutate pe electrod / Weight per electrode	g	22.60	36.50	47.50	68.50	103.50		
Nr de fire pe pachet / Pcs. per innerbox	n°	176	108	115	82	55		
Greutate pachet / Weight per innerbox	kg	4.0	4.0	5.5	5.5	5.5		
Nr de fire pe cutie / Pcs. per outerbox	n°	528	324	345	246	165		
Greutate pe cutie / Weight per outerbox	kg	12.0	12.0	16.5	16.5	16.5		
Cod / Code		W0002 88561	W0002 88562	W0002 88563	W0002 88564	W0002 88565		
Cod / Code VPM (vacuum pack mediu)		W0002 88567	W0002 88568	W0002 88569	W0002 88570	W0002 88571		

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