

STARINOX E308L - HP

ELECTROD RUTILIC / RUTILE ELECTRODE

CLASIFICARE / STANDARDS

EN 1600 (EN ISO 3581-A): AWS A5.4:	E 19 9 L R 22 E 308L-17	
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AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Electrod cu invelis rutilic, cu emisii de fum reduse, pentru sudarea otelurilor inoxidabile austenice Cr-Ni. Reducerea emisiilor de fum contribuie la imbunatatirea mediului de lucru pentru sudori si spatii inchise. Temperatura maxima de lucru +300°C. Transferul metalului se face in picaturi fine, topire buna, usoara desprindere a zgurei. Ambalare vacuum: fara necesitate calcinare si conditii speciale de depozitare.

MAIN FEATURES

Fume reduced, coated electrode for welding austenitic stainless Cr-Ni. The reduced fume formation contributes to an improved working environment, for welders and in workshops. For operating temperatures of up to +300°C. Fine metal droplet transfer, good fusion, easy slag removal, excellent striking and restriking. Vacuumpacked: no redrying, no special storing conditions.

DOMENII DE APLICATIE

Constructii navale; Recipienti sub presiune, inclusiv pentru industria chimica si petrochimica; Fabricarea tevilor.

MAIN APPLICATIONS

Ship building; Vessels, boilers fabrication (chemical and petrochemical); Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



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

CURRENT / CURRENT: DC+

RANDAMENT / EFFICIENCY: 100%

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

C	Mn	Si	S	P	Ni	Cr	FN (WRC)		
≤ 0.03	0.80	0.90	≤ 0.020	≤ 0.025	10.50	19.00	5 - 10		

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J +20°C	
Stare sudată/As welded	≥ 520	≥ 350	≥ 30	≥ 50	

DEPOZITARE - CALCINARE

Ambalare vacuum.
Odata deschis pachetul, a se pastra la 90° - 150° C.
Reuscarea electrozilor la 250-300° C / 2h max. de 5 ori.

STORAGE - REBAKING

*Vacuum packed.
Once opened, store at 90° - 150° C.
Re-dry moist electrodes 250-300° C / 2h max 5 times.*

CURENTE DE SUDARE / AMPERAGE

2.5	3.20	4.0							
70 - 80	110 - 120	125 - 135							

AMBALARE / PACKING: (VPS)

Diametru	mm	2.5	3.20	4.0					
Lungime / Length	mm	300	350	350					
Greutate pe electrod / Weight per electrode	g	18.6	35.2	53.3					
Nr de fire pe pachet / Pcs. per innerbox	n°	28	22	18					
Greutate pachet / Weight per innerbox	kg	0.52	0.78	0.95					
Nr de fire pe cutie / Pcs. per outerbox	n°	448	308	216					
Greutate pe cutie / Weight per outerbox	kg	8.3	10.8	11.5					
Cod / Code		W0002 88850	W0002 88851	W0002 88852					

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