

**FILCORD C**

SARMA PLINA CUPRATA / COPPER COATED SOLID WIRE

CLASIFICARE / STANDARDS

AWS A5.18-93:	ER70S-6
EN ISO 14341-A:	G423 C G3Si1
EN ISO 14341-A:	G424 M G3Si1

AUTORIZARI / APPROVALS

TÜV:	G42 2(M)G 3Si1	GL:	3YS
DB:	42.116.01	RINA:	SG42-52A3
ABS:	3SA-3YSA	BV:	SA3M-SA3YM

CARACTERISTICI PRINCIPALE

Sarma plina cuprata pentru sudare in mediu de gaz protector in toate pozitiile. Se utilizeaza ca gaz de protectie Ar/CO₂, Ar/CO₂/O₂ sau CO₂. Indicat pentru sudarea intr-o singura sau mai multe treceri a otelurilor nealiate, cu rezistenta de rupere la tractiune pana la 560 N/mm² (tip SG55J2G3 EN 10025 FE 510/St52 sau similar). Arc electric stabil, stropire redusa, aspect estetic al cordonului.

MAIN FEATURES

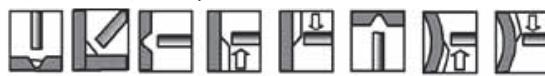
Copper coated solid wire for GMAW welding in all position. To be used with Ar/CO₂, Ar/CO₂/O₂ or CO₂ shielding gas. Suitable for single pass or multipass welding of non alloy steels, with tensile strength up to 560 N/mm², type SG55J2G3 EN 10025 (FE 510/St 52) and similar. Stable electric arc, good extetrical bead, very low spatters.

DOMENII DE APlicatie

Constructii navale, boiere (inclusiv cele din industria petrochimica); Industria constructoare de masini; Constructii metalice; Fabricarea tevilor; Constructia autovehiculelor si aplicatii electrocasnice; Constructii feroviare.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry); Industrial machinery construction; Metal working industry; Pipes fabrication; Car, bus production and electro-domestic appliances; Coachbuilders.

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: Ar / CO₂- Ar / CO₂/ O₂- CO₂
M2, M3, C1 (EN 439)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cu			
0.06 - 0.13	1.3 - 1.6	0.70 - 1.00	≤ 0.025	≤ 0.025	0.25			

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -30°C	Kv J -40°C
Ar/CO ₂ (M21)	Stare sudata/As welded	510 - 560	≥ 430	≥ 24	≥ 70	≥ 47
CO ₂	Stare sudata/As welded	510 - 560	≥ 430	≥ 24	≥ 47	

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm					
		0.6	0.8	1.0	1.2	1.6	
B 300	16 kg	W000282634	W000282640	W000282651	W000282660	W000282669	
B 300/SS	16 kg		W000282641	W000282652	W000282661	W000282670	
S 300	15 kg		W000282638	W000282649	W000282658	W000282667	
S 300/SS	15 kg		W000282639	W000282650	W000282659	W000282668	
S 200	5 kg	W000282632	W000282636	W000282647			
SQPA	250 kg		W000282645	W000282656	W000282665		
Drum	200 kg					W000282673	
Drum	400 kg		W000282644	W000282655	W000282664		

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