

EI 62 H

ELECTROD RUTIL-BAZIC / RUTIL-BASIC ELECTRODE

CLASIFICARE / STANDARDS

DIN 8555:	E 14 - 60	
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AUTORIZARI / APPROVALS
CARACTERISTICI PRINCIPALE

Electrodul EI 62H este un electrod cu invelis ruti-bazic pentru incarcarea prin sudare a pieselor supuse frecarii metal pe metal si usoara abraziune. Electrozii sudeaza cu arc stabil, fara stropi, topire uniforma si linistita. Zgura se desprinde usor dupa solidificare.

MAIN FEATURES

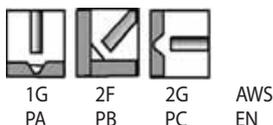
The electrode EI 62H is a rutile-basic covered electrode for hardfacing. The weld metal has an excellent resistance to low-stress abrasion and metal to metal wear. Electrodes weld with a stable arc and very low spattering loss. The slag is easy to remove.

DOMENII DE APLICATIE

Incarcare

MAIN APPLICATIONS

Hardfacing

POZITII DE SUDARE / WELDING POSITIONS


CURRENT / CURRENT: DC (+)
RANDAMENT / EFFICIENCY: 100%
DURITATE / HARDNESS: 55 - 60 HRC

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

C	Mn	Cr	Mo	V	W	Si			
0.70 - 1.00	0.30 - 0.60	3.50 - 5.00	2.50 - 9.50	1.50 - 2.50	2.00 - 3.00	0.80 - 1.60			

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

Tratament termic/Heat treatment				
Stare sudată/As welded	55 ÷ 60 HRC			

DEPOZITARE - CALCINARE

A se pastra in locuri uscate la temperatura camerei.
 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

3.20	4.00	5.00						
135 ÷ 150	180 ÷ 200	220 ÷ 250						

AMBALARE / PACKING

	mm	3.2	4.00	5.00				
Diametru	mm	3.2	4.00	5.00				
Lungime / Length	mm	450	450	450				
Greutate pe electrod / Weight per electrode	g	56.5	80.2	124.0				
Nr de fire pe pachet / Pcs. per innerbox	n°	99	69	44				
Greutate pachet / Weight per innerbox	kg	5.5	5.5	5.8				
Nr de fire pe cutie / Pcs. per outerbox	n°	297	207	132				
Greutate pe cutie / Weight per outerbox	kg	16.5	16.5	16.5				
Cod / Code		050124 325 450	050124 400 450	050124 500 450				

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