

# EI 62 H

## ELECTROD RUTIL-BAZIC / RUTIL-BASIC ELECTRODE

**CLASIFICARE / STANDARDS**

DIN 8555: E 14 - 60

**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**

 1G 2F 2G AWS  
 PA PB PC EN

**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**

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.