

**CLASIFICARE / STANDARDS**

|                             |             |
|-----------------------------|-------------|
| SR EN 1600 (EN ISO 3581-A): | E 199 LR 12 |
| AWS A5.4:                   | E308L-16    |

**AUTORIZARI / APPROVALS**
**CARACTERISTICI PRINCIPALE**

Electrozi cu invelis semi-bazic ce depun un metal cu un continut de carbon de max. 0.04%, destinat sudarii otelurilor inoxidabile austenitice cu 16-20% Cr si 8-12% Ni de tipul AISI 302, 304, 304L, 305. Rezistenta buna la coroziune intercrystalina. Comportare la sudura excelenta, fara stropire, dupa solidificare zgura se indeparteaza foarte usor. Temperatura maxima de lucru +300°C. Metalul depus are un continut de ferita controlat.

Alte materiale de baza pentru care se recomanda:

- X 5 CrNi 189, X 3 CrNi 189, X 10 CrNiTi 18.10 - DIN 17440
- W1.4301, W1.4306, W1.4541, W1.4550 - Werkstoff.

**MAIN FEATURES**

*Semi-basic electrode suitable for welding of austenitic steels having 16-20% Cr and 8-10% Ni (i.e. AISI 308 and 308L). Deposit with a carbon content max. 0.04%. Particularly suitable for food industry, chemical and nuclear applications. High resistance to intergranular corrosion. Excellent weldability with a spatter free arc; self releasing slag combined with a very smooth bead appearance. Maximum service temperature: +300°C.*

*It is recommended for the materials:*

- X 5 CrNi 189, X 3 CrNi 189, X 10 CrNiTi 18.10 - DIN 17440
- W1.4301, W1.4306, W1.4541, W1.4550 - Werkstoff.

**DOMENII DE APLICATIE**

Recipienti, inclusiv pentru industria chimică si petrochimică;  
Fabricarea tevelor; Constructii civile.

**MAIN APPLICATIONS**

*Vessels, boilers fabrication (including chemical and petrochemical); Pipes fabrication; Metal working industry*

**POZITII DE SUDARE / WELDING POSITIONS**


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

**CURRENT / CURRENT:** DC+, AC

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

| C      | Mn          | Si          | S     | P       | Ni         | Cr          | FN (WRC)   |  |  |
|--------|-------------|-------------|-------|---------|------------|-------------|------------|--|--|
| ≤ 0.04 | 0.50 - 1.00 | 0.60 - 0.90 | 0.020 | ≤ 0.030 | 9.0 - 11.0 | 18.0 - 21.0 | 5.0 - 10.0 |  |  |

**CARACTERISTICI MECANICE / MECHANICAL PROPERTIES**

| Tratament termic/Heat treatment | Rm N/mm <sup>2</sup> | Rs N/mm <sup>2</sup> | E % 4d | Kv J +20°C |
|---------------------------------|----------------------|----------------------|--------|------------|
| Stare sudată/As welded          | ≥ 520                | ≥ 350                | ≥ 35   | ≥ 60       |

**DEPOZITARE - CALCINARE**

Inainte de sudare, electrozii se vor pastra in locuri uscate la temperatura camerei. Odata deschis tubul, a se pastra la 90° - 150°C.

**STORAGE - REBAKING**

*Keep dry and store at room temperature. Once opened, store at 90° - 150°C till use.*

**CURENTI DE SUDARE / AMPERAGE**

| 2.00    | 2.50    | 3.20     | 4.00      | 5.00      |  |  |  |  |
|---------|---------|----------|-----------|-----------|--|--|--|--|
| 30 - 60 | 60 - 80 | 80 - 100 | 110 - 140 | 130 - 180 |  |  |  |  |

**AMBALARE / PACKING: TUB / CAN**

|   | mm | 2.00              | 2.50              | 3.20              | 4.00              | 5.00              |  |  |  |
|---|----|-------------------|-------------------|-------------------|-------------------|-------------------|--|--|--|
| Diametru                                    | mm | 300               | 300               | 350               | 350               | 350               |  |  |  |
| Lungime / Length                            | mm | 300               | 300               | 350               | 350               | 350               |  |  |  |
| Greutate pe electrod / Weight per electrode | g  | 11.21             | 18.5              | 34.60             | 53.57             | 78.85             |  |  |  |
| Nr de fire pe pachet / Pcs. per innerbox    | n° | 330               | 200               | 130               | 85                | 58                |  |  |  |
| Greutate pachet / Weight per innerbox       | kg | 3.7               | 3.7               | 4.5               | 4.5               | 4.5               |  |  |  |
| Nr de fire pe cutie / Pcs. per outerbox     | n° | 990               | 600               | 390               | 255               | 174               |  |  |  |
| Greutate pe cutie / Weight per outerbox     | kg | 11.1              | 11.1              | 13.5              | 13.5              | 13.5              |  |  |  |
| Cod / Code                                  |    | 050303<br>200 300 | 050303<br>250 300 | 050303<br>325 350 | 050303<br>400 350 | 050303<br>500 350 |  |  |  |

Ambalarea in tuburi metalice ofera posibilitatea pastrarii electrozilor in medii cu umiditate atmosferica ridicata, eliminand necesitatea calcinarii dupa desigilarea tubului timp de maxim 4h. Capacul din plastic nu permite rostogolirea tubului si permite protectia electrozilor dupa desigilarea tubului.

*Packaging in tin cans offers the possibility of keeping the electrodes in highly humid environments, thus eliminating the necessity of rebaking once the can opened. The plastic cap does not allow the can to roll over and protects the electrodes once the can opened.*

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