

EI 58 H

ELECTROD RUTIL-BAZIC / RUTIL-BASIC ELECTRODE



CLASIFICARE / STANDARDS

DIN 8555: E I 6 - 60 coated

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Electrodul EI 58H este un electrod cu invelis ruti-bazic pentru incarcarea prin sudare a subansamblelor supuse la soc si la abraziune. Electrozi sudeaza cu arc stabil, fara stropi, topire uniforma linistita. Zgura se desprinde usor dupa solidificare.

MAIN FEATURES

The electrode EI 58H is a rutile-basic covered electrode for hardfacing. parts subject to extremely severe working conditions, involving a combination of impact and abrasion. 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 PA 2F PB 2G PC AWS EN

CURRENT / CURRENT:

DC (+), AC

RANDAMENT / EFFICIENCY:

100%

DURITATE / HARDNESS:

the first layer - 550 HB /
the second layer - 57-62 HRC

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

C	Mn	Cr	Mo	V	Si				
0.40 - 0.60	0.20 - 0.40	6.50 - 8.00	0.40 - 0.60	0.40 - 0.60	0.40 - 0.60				

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

Tratament termic/Heat treatment					
Stare sudată/As welded	57 ÷ 62 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							
100 ÷ 120	140 ÷ 160	180 - 210							

AMBALARE / PACKING

Diametru	mm	3.20	3.20	4.00	5.00				
Lungime / Length	mm	350	450	450	450				
Greutate pe electrod / Weight per electrode	g	37	48.5	70.5	112.5				
Nr de fire pe pachet / Pcs. per innerbox	n°	108	113	78	49				
Greutate pachet / Weight per innerbox	kg	4.0	5.5	5.5	5.5				
Nr de fire pe cutie / Pcs. per outerbox	n°	324	339	234	147				
Greutate pe cutie / Weight per outerbox	kg	12.0	16.5	16.5	16.5				
Cod / Code		050123 325 350	050123 325 450	050123 400 450	050123 500 450				

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