

STARINOX 310

ELECTROD BAZIC / LOW HYDROGEN ELECTRODE



CLASIFICARE / STANDARDS

SR EN 1600 (EN ISO 3581-A):	E 25 20 B 12
AWS A5.4:	E310-15

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Electrod cu invelis bazic pentru sudarea otelurilor inoxidabile refractare cu 25% Cr si 20% Ni tip AISI 310. Destinat de asemenea sudarii imbinarilor disimilare, intre oteluri carbon si oteluri inoxidabile. Comportare buna la sudare, fara stropire, dupa solidificare zgura se indeparteaza usor. Temperatura maxima de lucru +1150°C. Alte materiale de baza care se recomanda:

- X 12 CrNi 25.21 - DIN 17440
- W1.4845, W1.4849 - Werkstoff

MAIN FEATURES

Full austenitic basic electrodes, suitable to weld heat resisting alloys (up to 1150°C), containing 25% Cr and 20% Ni (AISI 310). Excellent weldability with a spatter free arc; self-releasing slag combined with a very smooth bead appearance. It is recommended for the materials:

- X 12 CrNi 25.21 - DIN 17440
- W1.4845, W1.4849 - Werkstoff

DOMENII DE APLICATIE

Recipienti inclusiv pentru industria chimica si petrochimica; Incarcare si placare.

MAIN APPLICATIONS

Vessels, boilers fabrication (chemical and petrochemical); Hardfacing and weld overlay.

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			
0.08 - 0.15	1.50 - 2.50	0.30 - 0.75	≤ 0.020	≤ 0.030	20.0 - 22.0	25.0 - 28.0			

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 4d	Kv J +20°C	
Stare sudată/As welded	≥ 550	≥ 400	≥ 30	≥ 60	

DEPOZITARE - CALCINARE

A se pastra in locuri uscate la temperatura camerei. Odata deschis pachetul, a se pastra la 90° - 150°C. Calcinare: 1 h la 280°C max. de 5 ori.

STORAGE - REBAKING

Keep dry and store at room temperature. Once opened, store at 90° - 150°C. Rebaking: 2 h min. at 250-300°C.

CURENTI DE SUDARE / AMPERAGE

2.50	3.20	4.0	5.00						
60 - 80	80 - 100	110 - 130	130 - 180						

AMBALARE / PACKING

Diametru	mm	2.5	3.20	4.0	5.0				
Lungime / Length	mm	300	350	350	350				
Greutate pe electrod / Weight per electrode	g	18.5	34.6	53.57	78.85				
Nr de fire pe pachet / Pcs. per innerbox	n°	200	130	85	58				
Greutate pachet / Weight per innerbox	kg	3.7	4.5	4.5	4.5				
Nr de fire pe cutie / Pcs. per outerbox	n°	600	390	255	174				
Greutate pe cutie / Weight per outerbox	kg	11.1	13.5	13.5	13.5				
Cod / Code		050307 250 300	050307 325 350	050307 400 350	050307 500 350				

Ambalarea in tuburi metalice ofera posibilitatea pastrarii electrozilor in medii cu umiditate atmosferica ridicata, eliminand necesitatea calcinarii dupa desigilarea tubului. 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.