



FILCORD 35

SARMA PLINA CUPRATA / COPPER COATED SOLID WIRE

CLASIFICARE / STANDARDS

AWS A5.28-96 : ER 70S-A1
EN 440-94 : G2Mo
EN 12070-99 : G Mo Si

AUTORIZARI / APPROVALS

TÜV : G2 Mo - G Mo Si

CARACTERISTICI PRINCIPALE

Sarma plina cuprata, aliata cu 0,50 % Mo, pentru oteluri rezistente la 450°C utilizate in centrale termice si instalatii petrochimice, destinata de asemenea reconditionarii prin sudare a pieselor. Destinata sudarii otelurilor cu compozitie chimica similara cum ar fi table tip ASTM 204 si tevi A335-P1. Se poate utiliza ca gaz de protectie CO₂ sau amestec Ar/CO₂.

MAIN FEATURES

Copper coated solid wire, 0,50 % Mo alloyed, for heat resisting steels, up to 450° C, used in thermal or thermic and petrochemical applications: Suitable also for facing on casting, for casting repairs. Suitable for heat resisting steels, such as plate ASTM 204 e pipe A335-P1 or casting with same composition. Can be used with Ar/CO₂ Mix or CO₂ shielding gas.

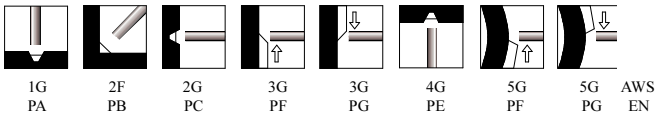
DOMENII DE APLICATIE

Cazangerie
Industria chimica, petrochimica
Fabricarea tevilor

MAIN APPLICATIONS

Vessels, boilers fabrication
Chemical, petrochemical industry
Pipes fabrication

POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT : DC+

GAZ : Ar / CO₂ - CO₂
M2, C1 (EN 439)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

GAS	C	Mn	Si	S	P	Mo	Ni	Cu	Al
Mix/CO ₂	≤ 0.12	≤ 1.30	0.50 - 0.70	≤ 0.020	≤ 0.020	0.40 - 0.60	≤ 0.15	≤ 0.35	≤ 0.02

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Trat. termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E% 5d	Kv J +20°C	
Mix	Stare sudata/ As welded	≥ 560	≥ 460	≥ 22	≥ 47	
Mix	Dupa / After 620°C x 1h	≥ 515	≥ 400	≥ 24	≥ 47	

AMBALARE STANDARD / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/ Weight	Diametru mm/Diameter mm					
		1.0	1.2				
K 300/SS	15 Kg	2605636	2605638				

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

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