



# FILCORD TENAX

SARMA PLINA CUPRATA / COPPER COATED SOLID WIRE

## CLASIFICARE / STANDARDS

AWS A5.28-96 : ER100S-G  
EN 12534-99 : G 55 2 M MnB 3 Ni Cr Mo

## AUTORIZARI/ APPROVALS

## CARACTERISTICI PRINCIPALE

Sarma plina cuprata slab aliata cu Ni-Cr-Mn, pentru sudare in mediu de gaz protector in toate pozitile de sudare. Se recomanda a se utiliza in amestec de gaze (Ar/CO<sub>2</sub>) dar poate fi utilizata si in mediu de CO<sub>2</sub>. Poate fi utilizata pentru sudarea otelurilor slab aliata, cu limita de curgere de 550 N/mm<sup>2</sup> si cu o rezistenta la rupere de 750 N/mm<sup>2</sup> (tip T1, N.A.ETRA, VELDOX sau similare). Poate fi utilizata si cand sunt necesare inalte caracteristici de tenacitate la temperaturi scazute. Pentru a fi obtinute cele mai bune rezultate se recomanda sudarea cu o energie liniara cat mai mica.

## MAIN FEATURES

Copper coated low alloy wire with Ni-Cr-Mn, for GMAW welding in all positions. To be used preferably with Ar/CO<sub>2</sub> shielding gas, but it can be used with CO<sub>2</sub> too. Suitable for single pass or multipass welding of low alloy steels, with minimum yield strength of 550 N/mm<sup>2</sup> and with tensile strength up to 750 N/mm<sup>2</sup> (type T1, N.A.ETRA, VELDOX and similar). It can be used also when good toughness characteristic in low temperature are required. To obtain the best result, the use with low heat input is advised. Good extetical bead and low spatters..

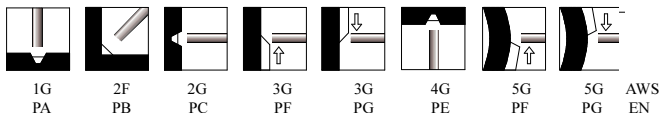
## DOMENII DE APLICATIE

Constructii navale, boilere (inclusiv cele din industria petrochimica)  
Industria constructoare de masini,  
Constructii metalice

## MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry)  
Industrial machinery construction  
Metal working industry

## POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT : DC +  
GAZ : Ar / CO<sub>2</sub>-CO<sub>2</sub>  
(M2) (C1) EN 439

## ANALIZA CHIMICA A SARMEI % / ALL - WELD METAL CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Ni	Cr	Mo		
0.06-0.10	1.30 - 1.60	0.60 - 0.80	≤ 0.025	≤ 0.025	0.40 - 0.70	0.40-0.60	0.15-0.30		

## CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Trat. termic/Heat treatment	Rm N/mm <sup>2</sup>	Rs N/mm <sup>2</sup>	E % 5d	Kv J -20°C	HB
Ar/CO <sub>2</sub> (M21)	Stare sudata/As welded	650 - 750	≥ 550	≥ 18	≥ 70	200

## AMBALARE / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/ Weight(Kg)	Diametru mm/Diameter mm					
		1.0	1.2	1.6	2.0		
K 300 R	16 Kg	2602639	2602647	2602662	2602670		
K 300/SS	16 Kg	2603684	2603886	2603694			
LP	250 Kg	2600822	2600823				
LP4	400 Kg			2600828			