



FLUX AS 55

FLUX TOPIT PENTRU SUDARE / SUBARC FUSED FLUX

CLASIFICARE/ STANDARDS

EN 760 : S F MS 1 67 AC
 EN 756 : S 42 0 MS S1 (AS 25)
 S 42 0 MS S2 (AS 35)
 AWS A5.17 : F7A0-EL12 (AS 25)
 F7A0-EM12K (AS 35)

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Flux topit ce contine Mn si Si, pentru sudarea otelurilor carbon in unul sau mai multe straturi, folosind una sau mai multe sarme. Zgura se desprinde bine in cazul sudurilor executate in sanfren. Recomandat in special pentru sudarea cu mare viteza a tablelor subtiri (3 - 5 mm). Poate fi utilizat deasemenea si in cazul sudurilor executate pe placute de cupru.

MAIN FEATURES

Fused flux additive in Mn and Si. suitable for carbon steel welding, in single or multipass technique and single or multiwire applications. Good slag removal in fillet and groove welds. Especially suitable for high speed welding on thin thicknesses (3 - 5 mm). It can also be used for welding on copper bar.

DOMENII DE APLICATIE

Stalpi de iluminat
 Rezervoare de apa
 Constructii

MAIN APPLICATIONS

Lamps and telephone poles
 Light boiler works
 Structural steelworks

CONSTITUENTI PRINCIPALI % (Valori tipice) / MAIN CONSTITUENTS % (Typical values)

Ca0 = 2 Mn0 = 45

Indice de bazicitate / Basicity Index: 0.9ca.

Si02 = 22 Ti02 = 20 CaF2 = 3

(in acord cu Boniszewski / according to Boniszewski)

CURRENT - CALCINARE

DC pana la 900 A pe sarma.
 350°C pentru 2 ore.

CURRENT - REBAKING

DC up to 900 A per wire.
 350°C for 2 h.

ANALIZA CHIMICAA METALULUI DEPUR % / ALL - WELD METAL CHEMICAL ANALYSIS %

Sarma/Wire	C	Mn	Si	S	P	Cu	Ni	Cr	Mo
AS 25	0.04 - 0.06	0.9 - 1.3	0.1 - 0.3	≤ 0.02	≤ 0.03	≤ 0.35			
AS 35	0.04 - 0.06	1.1 - 1.5	0.1 - 0.4	≤ 0.02	≤ 0.03	≤ 0.35			

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

Sarma/ Wire	Trat. termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -0° c	Kv J - 20°C
AS 25	Stare sudata/As welded	490 - 560	≥ 400	≥ 22	≥ 40	≥ 27
AS 35	“ “ “ “	520 - 600	≥ 420	≥ 22	≥ 40	≥ 27

AMBALARE STANDARD/ STANDARD PACKAGING

Sac/Bag	25 Kg	3300217			Butoi/Drum	270 Kg	3300225
Granulometria/ Grain size		40 x 150					de comun acord to be agreed

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