

ALTIG CrMo5

BAGHETE TIG / GTAW ROD

CLASIFICARE / STANDARDS

EN 12070-99 : W CrMo5Si
 AWS A5.28-93 : ER 80S-B6 (AWS A5.9-81: ER 502)

AUTORIZARI / APPROVALS
CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor aliate cu 5,00% Cr, 0,50% Mo rezistente la temperaturi inalte. Destinate sudarii straturilor de radacina la tubulaturi. Este obligatorie protejarea radacinii cu gaz inert pentru a preveni oxidarea cromului. Se recomanda preincalzirea la 200-300 ° C inainte de sudare si mentinerea acestei temperaturi pe durata sudarii.

MAIN FEATURES

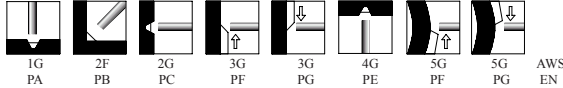
Tig rod for low alloy creep resistant steels of the 5,00%Cr, 0,50% Mo type. Suitable for root pass on pipe welding. Its mandatory to use inert backing gas to avoid chrome oxidation. Preheating (200-300 ° C) of peace and interpass (200-300 ° C) are suggested.

DOMENII DE APLICATIE

Cazangerie
 Industria chimica si petrochimica

MAIN APPLICATIONS

Vessels, boilers fabrication
 Chemical, petrochemical industry



CURRENT / CURRENT : DC -
GAZ/ GAS : Ar (11) EN 439

ANALIZA CHIMICA A BAGHETEI % / ROD CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Mo	Cr			
0.03 - 0.10	0.30 - 0.70	0.43 - 0.60	≤ 0.020	≤ 0.020	0.50 - 0.80	5.50 - 6.50			

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Trat. termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J +20° C
Ar	Dupa/after 745° C x 1h	≥ 650	≥ 570	≥ 22	≥ 47

AMBALARE STANDARD / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/Weight	Diametru mm x lungime mm / Diameter mm x length mm					
		2.0 x 1000	2.4 x 1000				
Tub/Tube	5 Kg	0839914	0839916				