



FLUXOFIL 19 HD

SARME TUBULARE / FLUX CORED WIRE

CLASIFICARE / STANDARDS

EN 758 : T 46 2 P C 1 H5
AWS A5.20 : E71T-1H4

AUTORIZARI / APPROVALS

ABS : 3Y40SA H5 RINA : SG523 HHH
LRS : 3S, 3Y46 H5 M.M : GA-A1/GA-A12
DNV : IIIY40S H5 TÜV
GL : 3Y40S H5
BV : 3, 3Y40S H5

CARACTERISTICI PRINCIPALE

Sarma tubulara cuprata pentru sudarea intr-un singur strat sau in mai multe straturi. Randamentul de depunere este ridicat, fara stropi si cu un aspect al cordonului regulat chiar si pe table cu calamina. Recomandat in mod deosebit pentru utilizarea in constructii navale, in special in pozitia vertical ascendent, permitand realizarea unor cordoane de mici dimensiuni. Se poate suda folosind CO₂ de mare puritate. Este recomandat pentru sudarea otelurilor carbon de tipul Fe430 - Fe510, cu bune caracteristici de tenacitate pana la -20° C.

MAIN FEATURES

Rutile seamless copper coated cored wire, for welding metal constructions in single or multipass technique. Designed for high deposition rate welding, stable and low spattering arc characteristics. Easy slag removal and good bead appearance, even on oxidized plates. Particularly designed for shipbuilding applications, especially for vertical up welding, even without waving the torch in order to obtain small size beads. Shielding gas: CO₂. For welding carbon manganese steels like Fe 430 - Fe 510, with good impact properties down to -20° C.

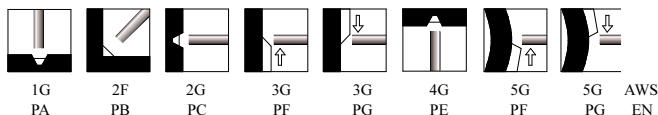
DOMENII DE APLICATIE

Constructii navale
Constructii feroviare si de material rulant
Masini agricole
Constructii de poduri, masini de decopertat, etc..

MAIN APPLICATIONS

Shipbuilding
Rolling stock construction
Agriculture machines
Bridge cranes, cranes, earth moving machines.

POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT : DC+
GAZ/GAS : CO₂
H₂ DIFF. / DIFF. H₂ : 3 ml / 100 g max

ANALIZA CHIMICA A METALULUI DEPUZ % / ALL - WELD METAL CHEMICAL ANALYSIS %

GAZ/GAS	C	Mn	Si	S	P				
CO ₂	0.03 - 0.07	1.20 - 1.60	0.35 - 0.70	≤ 0.020	≤ 0.020				

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ/GAS	Trat. termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -20°C	
CO ₂	Stare sudata/As welded	530 - 640	≥ 460	≥ 24	≥ 80	

AMBALARE / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/Weigh t	Diametru mm/Diameter mm					
		1.0	1.2	1.4	1,6		
K 300	16 Kg		2653380	2653382	2653384		
C 5	5 Kg	2653400	2653402				
K300(D52)	16Kg		2639310		2639314		

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

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