



FILCORD D

SARMA PLINA CUPRATA/ COPPER COATED SOLID WIRE

CLASIFICARE / STANDARDS

AWS A5.18-93 : ER70S-6
EN 440-94 : G4 Si1

AUTORIZARI / APPROVALS

ABS : 3SA-3YSA
RINA : SG52-56A3
TÜV : SG 3 M21CY4654
DB : N° 42.047.02
GL : 3Y40S

CARACTERISTICI PRINCIPALE

Sarma plina cuprata pentru sudare in mediu de gaz protector in toate pozitiile. Se utilizeaza ca gaz de protectie Ar/CO₂, Ar/CO₂/O₂ sau CO₂. Indicat pentru sudare intr-o singura sau mai multe treceri a otelurilor nealiate, pentru oțeluri carbon si pentru oțeluri cu granulație fina, cu rezistența de rupere la traciune pana la 590 N/mm² (tip S355J2G3 EN 10025 FE 510/St52 sau similar). Continutul mai mare de Si-Mn imbunatateste caracteristicile mecanice si dezoxidarea metalului depus, ceea ce conduce la o puritate mai mare a metalului si reduce efectul impuritatilor.

MAIN FEATURES

Copper coated solid wire to be used for GMAW welding in all position. To be used with Ar/CO₂, Ar/CO₂/O₂ or CO₂ shielding gas. Suitable for single pass or multipass welding of non alloy steels, for C-Mn steels and for fine grain steels, with tensile strength up to 590 N/mm² (type S355J2G3 EN 10025 FE 510/St52 and similar). The higher Si-Mn content improves high mechanic characteristic and a moderately deoxidizer deposit and so less sensible to defectiveness derivables from possible presence of mill scale or other impurities in the parent metal.

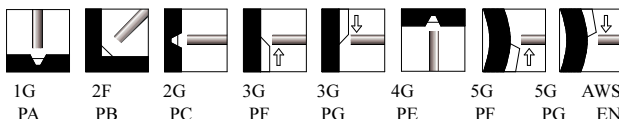
DOMENII DE APLICATIE

Constructii navale, boilere (inclusiv cele din industria petrochimica)
Industria constructoare de masini,
Constructii metalice
Fabricarea tevelor
Constructia autovehiculelor si aplicatii electrocasnice
Constructii feroviare

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry)
Industrial machinery construction
Metal working industry
Pipes fabrication
Car, bus production and electro-domestic appliances
Coachbuilders
Rolling stock construction

POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT : DC +

GAZ : Ar / CO₂- Ar / CO₂/O₂-CO₂
M2, M3, C1(EN 439)

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

C	Mn	Si	S	P	Cu			
0.06 - 0.10	1.61 - 1.75	0.80 - 1.00	≤ 0.025	≤ 0.025	≤ 0.25			

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAS	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -20°C	Kv J -30°C
Ar/CO2(M21)	Stare Sudata/As welded	530 - 600	≥ 460	≥ 24	≥ 80	≥ 70

AMBALARE / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/ Weight(Kg)	Diametru mm/Diameter mm					
		0.8	1.0	1.2	1.6		
K 300	16 Kg	2601425	2601433	2601441	2601466		
K300/SS	16 Kg	2603827	2603835	2603843			
D 300	15 Kg	2606523	2606531	2606549			
C5	5 Kg	2605085	2605046	2605089			
LP	250Kg	2605038	2605046	2605053			