



# FILCORD TENAX S

## SARMA PLINA CUPRATA/ SOLID WIRE

### CLASIFICARE / STANDARDS

**AWS A5.28-96** : ER100S-1  
**EN 12534-99** : G 62 3 M Mn 3 Ni 1 Cr Mo

### AUTORIZARI / APPROVALS

**DB** : N.42.047.03

### CARACTERISTICI PRINCIPALE

Sarma plina cuprata slab aliata cu Ni-Cr-Mn, pentru sudarea in mediu de gaz protector. Se recomanda a se utiliza de preferinta in mediu de Ar/CO<sub>2</sub> dar poate fi utilizata de asemenea si in mediu de CO<sub>2</sub>. Poate fi utilizata pentru sudarea otelurilor slab aliate, cu limita de curgere de 650 N/mm<sup>2</sup> si cu o rezistenta la rupere de 850 N/mm<sup>2</sup> (tip T1, T1A, T1B, N.A.ETRA65-70, VELDOX700, HY80, HY90, BH65-70, S690 Q(EN 10132-2) 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 650 N/mm<sup>2</sup> and with tensile strength up to 850 N/mm<sup>2</sup> (type T1, T1A, T1B, N.A.ETRA65-70, WELDOX700, HY80, HY90, BH65-70, S690 Q(EN 10132-2) 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..

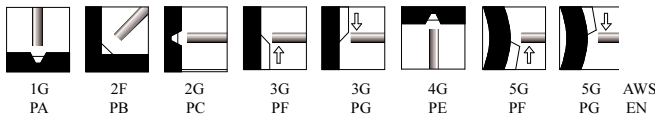
### DOMENII DE APLICATIE

Constructii navale,  
 Recipienti, inclusiv cele din industria petrochimica  
 Industria constructoare de masini  
 Constructii metalice  
 Platforme marine

### MAIN APPLICATIONS

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

### 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	Cu	V
0.06 - 0.09	1.50 - 1.70	0.50 - 0.70	≤ 0.015	≤ 0.015	1.40 - 1.60	0.30 - 0.40	0.20 - 0.30	≤ 0.18	0.08 - 0.10

### 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 -30°C
ArCO <sub>2</sub>	Stare sudata/As welded	750-850	≥ 650	≥ 16	≥ 50

### AMBALARE / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/ Weight(Kg)	Diametru mm/Diameter mm			
		1.0	1.2		
K 300 R	16	2604106	2604114		
K300/SS	16	2604118	2604120		
LP	250	2600765	2600773		

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

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