



FLUXOFIL 20 HD

SARME TUBULARE / FLUX CORED WIRE

CLASIFICARE / STANDARDS

EN 758 : T 46 4 1 Ni P M 1 H5
AWS A5.29 : E8T1-Ni1

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma tubulara cuprata rutilica pentru sudarea in toate pozitiile a otelurilor aliate cu aprox. 1% Ni. Destinata sudarii numai in protectie de amestec de gaze Ar/CO₂ in special pentru sudarea automata circulara a tevilor. Stropire foarte mica, usoara desprindere a zgurii, excelenta estetica a cordonului de sudura lipsit total de pori.

MAIN FEATURES

Rutile copper coated flux cored wire, for welding in all position of carbon and low alloy steels with approximately 1% Ni. Designed for Ar/CO₂ shielding gas especially for circumferential automatic welding of pipes. Low spatters, easy slag removal and good bead aspect.

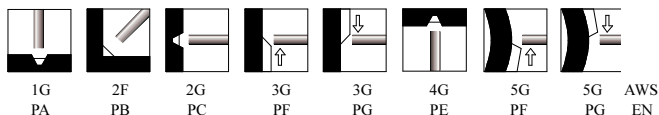
DOMENII DE APLICATIE

Constructii navale
Platforme Offshore
Recipiente sub presiune
Constructii de poduri

MAIN APPLICATIONS

Shipbuilding
Offshore work
Pressure vessels
Bridge construction

POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT : DC+

GAZ/GAS : MIX (Ar / CO₂) (M21 - EN 439)

H₂ DIFF. / DIFF. H₂ : 3 ml / 100 gr max

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

GAZ/GAS	C	Mn	Si	S	P	Ni			
Mix	0.04 - 0.07	1.10 - 1.40	0.30 - 0.70	≤ 0.015	0 ≤ 0.015	0.70 - 0.9			

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ/GAS	Trat. termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -40°C	
Mix	Stare sudata/As welded	550 -670	≥ 490	≥ 24	≥ 80	
	Dopo/after 620°C x 1h					

AMBALARE / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/Weigh t	Diametru mm/Diameter mm					
		1.0	1.2				
K 300	16 Kg		2654300				

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