

CLASIFICARE / STANDARDS

AWS A5.18-93:	ER70S-6
EN 440-94:	G3Si1

AUTORIZARI / APPROVALS

ABS:	3SA-3YSA	RINA:	SG42-52A3
LRS:	3S-3YS H15	TÜV:	G42 2(M)G 3Si1
DNV:	III-YMS	GL:	3YS
BV:	SA3M-SA3YM	DB:	N° 42.047.01

CARACTERISTICI PRINCIPALE

Sarma plina cuprata pentru sudare in mediu de gaz protector in toate pozitile. Se utilizeaza ca gaz de protectie Ar/CO₂, Ar/CO₂/O₂ sau CO₂. Indicat pentru sudarea intr-o singura sau mai multe treceri a otelurilor nealiate, cu rezistenta de rupere la tractiune pana la 560 N/mm² (tip SG55J2G3 EN 10025 FE 510/St52 sau similar). Arc electric stabil, stropire redusa, aspect estetic al cordonului.

MAIN FEATURES

Copper coated solid wire 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, with tensile strength up to 560 N/mm², type SG55J2G3 EN 10025 (FE 510/St 52) and similar. Stable electric arc, good extetical bead, very low spatters.

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.

POZITII DE SUDARE / WELDING POSITIONS



1G PA 2F PB 2G PC 3G PF 3G PG 4G PE 5G PF 5G PG AWS EN

CURENT / CURRENT: DC+

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

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cu			
0.06 - 0.13	1.3 - 1.6	0.70 - 1.00	≤ 0.025	≤ 0.025	0.25			

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -20°C
Ar/CO ₂ (M21)	Stare sudată/As welded	510 - 560	≥ 430	≥ 24	≥ 70

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm					
		0.6	0.8	1.0	1.2	1.6	
B 300	16 kg	W000282634	W000282640	W000282651	W000282660	W000282669	
B 300/SS	16 kg		W000282641	W000282652	W000282661	W000282670	
S 300	15 kg		W000282638	W000282649	W000282658	W000282667	
S 300/SS	15 kg		W000282639	W000282650	W000282659	W000282668	
S 200	5 kg	W000282632	W000282636	W000282647			
SQPA	250 kg		W000282645	W000282656	W000282665		
Drum	200 kg					W000282673	
Drum	400 kg		W000282644	W000282655	W000282664		

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