SUPERBAZ

ELECTROD BAZIC / *LOW HYDROGEN ELECTRODE*

CLASIFICARE / ***STANDARDS***

EN 499:	E 42 4 B 42 H5
AWS A5.1:	E 7018
EN ISO 2560 - A:	E 42 4 B 42 H5

AUTORIZARI / ***APPROVALS***

LRS:	3m3Ym H5	**DB:**	N° 10.116.04
DNV:	3Y H10	**ABS:**	3Y
TÜV:	E42 4B	**ANR:**	3Y HH
BV:	3YHH	**GL:**	3Y H10

CARACTERISTICI PRINCIPALE

Electrozi bazici cu pulbere de fier in invelis, destinati structurilor puternic solicitate static si dinamic si sectiunilor groase din oteluri slab aliate, la temperaturi de pana la -40°C. Se recomanda pentru sudarea otelurilor urmatoare:

- OL 44.4; OL 52.2; OL 52.4; OL 50 - STAS 500/2
- K 41.6a; K47.6a - STAS 2883/3
- OT 450.1; OT 450.2; OT 450.3; OT 500.1; OT 500.2; OT 500.3 - STAS 600
- A32; D32; D36 - STAS 8324
- OCS 44.4a; OCS 52.5a - STAS 9021
- S185, S235, S275, S355 - EN 10025
- P235, P265, P295, P335 - EN 10028-2
- S275; S355; S420 - EN 10113-3

Arcul arde stabil. Bun aspect al cordonului cu stropire redusa. Zgura acopera bine randul de sudura, iar dupa solidificare se desprinde usor. Continutul de hidrogen difuzibil: max. 5 cm^3/ 100g M.D. Randamentul nominal efectiv: RE = 116%.

MAIN FEATURES

Heavy covered basic type electrode, designed for works highly strained at static and dynamic loadings. It is used in structural engineering, boilers, tanks and vehicle constructions and also bridges and shipbuilding. It is recommended for a service temperature down to 40°C. It is recommended for the materials:

- *OL 44.4; OL 52.2; OL 52.4; OL 50 - STAS 500/2*
- *K 41.6a; K47.6a - STAS 2883/3*
- *OT 450.1; OT 450.2; OT 450.3; OT 500.1; OT 500.2; OT 500.3 - STAS 600*
- *A32; D32; D36 - STAS 8324*
- *OCS 44.4a; OCS 52.5a - STAS 9021*
- *S185, S235, S275, S355 - EN 10025*
- *P235, P265, P295, P335 - EN 10028-2*
- *S275; S355; S420 - EN 10113-3*

The electrode welds with a stable arc and a very low spattering loss. The slag is easy to remove. It deposits a low hydrogen content weld metal. The diffusible hydrogen content of weld metal places the electrode in class B - low hydrogen content - max. 5 cm^3 / 100 g M.D. Weld metal recovery: RE = 116%.

DOMENII DE APLICATIE

Recipienti sub presiune, inclusiv pentru industria chimica si petrochimică, constructia de nave, sudarea tevilor, fabricarea platformelor marine.

MAIN APPLICATIONS

Vessels, boilers fabrication including for chemical petrochemical industry; ship buildings, pipes fabricatio; off-shore fabrication.

POZITII DE SUDARE / ***WELDING POSITIONS***

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

CURENT / ***CURRENT:*** DC+, AC

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

C	Mn	Si	S	P					
0.05 - 0.9	0.80 - 1.20	0.25 - 0.65	≤ 0.015	≤ 0.025					

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

Tratament termic/*Heat treatment*	Rm N/mm^2	Rs N/mm^2	E % 5d	Kv J -40°C
Stare sudată/*As welded*	510 - 640	≥ 430	≥ 24	≥ 47
Dupa/*after 620°C x 1h*	500 - 620	≥ 420	≥ 22	≥ 47

DEPOZITARE - CALCINARE

A se pastra in locuri uscate la temperatura camerei. Inainte de sudare electrozii se vor usca in mod obligatoriu timp de 2 ore la 250 ÷ 300°C.

STORAGE - *REBAKING*

Keep dry and store at room temperature. Rebaking: 2h min. at 250 ÷ 300°.

CURENTI DE SUDARE / ***AMPERAGE***

2.00	2.50	3.20	4.00	5.00	6.00				
50 - 80	65 - 90	120 - 140	160 - 190	210 - 230	210 - 230				

AMBALARE / ***PACKING***

Diametru	mm	2.00	2.50	2.50	3.20	3.20	4.00	4.00	5.00	6.00
Lungime / *Lenght*	mm	300	300	350	350	450	350	450	450	450
Greutate pe electrod / *Weight per electrode*	g	12.40	18.90	22.30	35.70	46.70	51.00	67.80	100.90	137.10
Nr de fire pe pachet / *Pcs. per innerbox*	n°	283	180	180	112	112	80	80	55	42
Greutate pachet / *Weight per innerbox*	kg	3.5	3.5	4.0	4.0	5.5	4.0	5.5	5.5	6.0
Nr de fire pe cutie / *Pcs. per outerbox*	n°	1132	740	540	336	336	240	240	165	126
Greutate pe cutie / *Weight per outerbox*	kg	10.5	10.5	12.0	12.0	16.5	12.0	16.5	16.5	18.0
Cod / *Code*		W0002 88304	W0002 88305	W0002 88306	W0002 88307	W0002 88308	W0002 88309	W0002 88310	W0002 88311	W0002 88312
Cod / *Code VPM (vacuum pack mediu)*				W0002 88313	W0002 88314	W0002 88315	W0002 88316	W0002 88317	W0002 88318	

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