

# SUPERTIT FIN

## ELECTROD RUTILIC / RUTILE ELECTRODE



### CLASIFICARE / STANDARDS

AWS A5.1:	E 6015
EN ISO 2560-A:	E 38 C R 12

### AUTORIZARI / APPROVALS

LRS:	ZY H15	SV:	ZH-
TÜV:	E 42 C R 12	GL:	ZY H15
DB:	N° 10.037.08	DNV:	3
ANR:	2-	ABS:	3

### CARACTERISTICI PRINCIPALE

Electrozi cu invelis rutilic de grosime medie, recomandat in special pentru sudarea constructiilor metalice usoare, tablelor subtile din otel carbon. Sunt indicati pentru sudarea otelurilor nealiate cu continut de carbon de maxim 0,25%, pentru structuri usoare. Utilizate pentru temperaturi pana la 570°C, ca de exemplu:

- OL 37.3, OL 44.2, OL 44.3 - STAS 50012
- OLT 35 - STAS 8185
- S185, S235, S275, S355 - EN 10025
- P235, P265, P275, P355 - EN 10028-2

Amorsare si rearsorsare usoare. Arcul este stabil, stropirea este foarte redusa atat in curent continuu cat si in curent alternativ. Aspect estetic al cordoanelor buna dezasarietate a zgurii.

### MAIN FEATURES

Rutile medium coated electrode, especially developed for welding mild steels for light metal constructions and thin sheets. Suitable for use in structural engineering, shipbuilding and vehicle, made of steels with max. 0.25% carbon for a service temperature up to 570°C, like:

- OL 37.3, OL 44.2, OL 44.3 - STAS 50012
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Excellent striking and re-striking qualities. The electrode welds with a stable arc and very spattering loss. The slag is self-releasing.

### DOMENII DE APLICATIE

Constructii metalice

### MAIN APPLICATIONS

Metal working industry

### POZITII DE SUDARE / WELDING POSITIONS



1G	2F	3G	4G	5G	6G	AWS
E6	E6	E6	E7	E7	E7	EN

### CURRENT / CURRENT: DC-, AC

Tensiune de mers in gol: min. 50V  
Minimum open circuit voltage

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

C	Mn	Si	S	P				
0.06 - 0.10	0.30 - 0.60	0.20 - 0.50	max. 0.03	max. 0.03				

### CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

Limita de curgere/Yield strength N/mm <sup>2</sup>	Rezistenta la rupere/Tensile strength N/mm <sup>2</sup>	Alungirea/Elongation A <sub>5.65</sub> %	Kv, 0°C
450 - 470	490 - 600	min. 24	min. 47

### DEPOZITARE - CALCINARE

A se pastra in locuri uscate la temperatura camerei.

### STORAGE - REBAKING

Keep dry and store at room temperature.

### CURENTI DE SUDARE / AMPERAGE

1.50	2.00	2.50	3.20	4.0	5.0				
30 - 50	40 - 60	50 - 90	110 - 135	160 - 180	180 - 210				

### AMBALARE / PACKING

Diametru	mm	1.50	2.00	2.50	3.20	4.0	5.0	6.0	8.0	10.0
Lungime / Length	mm	250	300	300	350	450	450	450	450	450
Greutate pe electrod / Weight per electrode	g	5.50	11.50	16.00	19.50	31.00	47.00	48.00	64.50	97.00
Numar de fire pe pachet / Nos. per innerbox	n°	291	315	237	230	139	93	92	92	60
Greutate pachet / Weight per innerbox	kg	2.2	3.5	3.8	4.5	4.5	3.8	4.5	5.8	6.0
Numar de fire pe cutie / Nos. per outerbox	n°	2354	1292	945	690	478	415	276	276	180
Greutate pe cutie / Weight per outerbox	kg	14.0	11.4	11.4	13.5	13.5	17.4	13.5	17.4	18.0
Cod / Code		W0001 88257	W0002 88258	W0002 88259	W0002 88260	W0002 88261	W0002 88262	W0002 88263	W0002 88264	W0002 88265

Datele mentionate pot fi modificate fara a notifica prestatii. / The above data may change without prior notice.