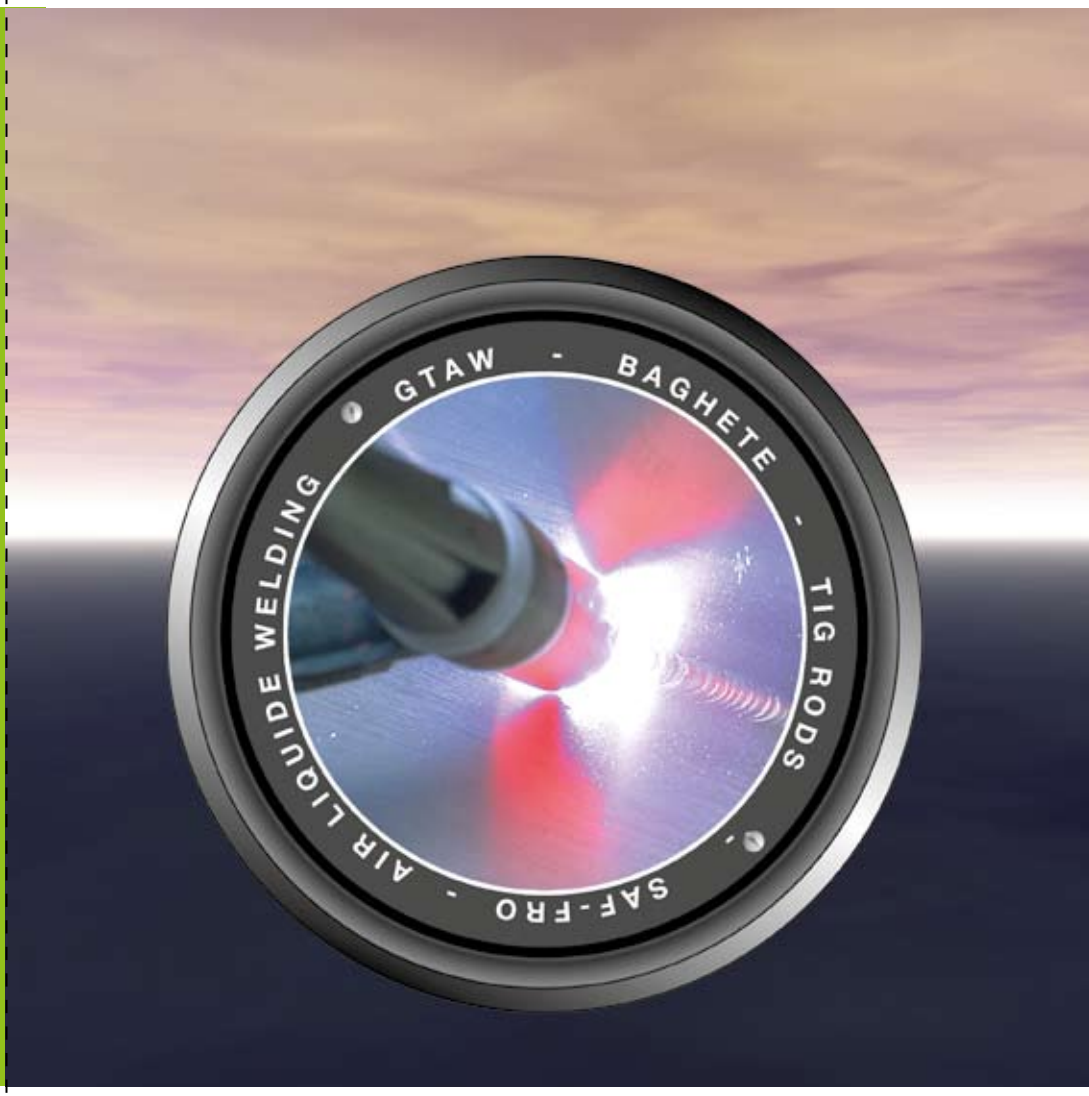
BAGHETE
TIG RODS



ALTIG SG1

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.18-93:	ER 70S-3
EN ISO 17632-A:	W 2 Si
DIN 8559:	WSG1

AUTORIZARI / ***APPROVALS***

CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor carbon. Bune caracteristici mecanice si de tenacitate.
Destinata sudarii straturilor de radacina la tevi, fara perna de gaz.

MAIN FEATURES

Tig rod for non alloy steels welding. Good mechanical and toughness properties.
Suitable for root pass on pipe welding, without backing gas.

DOMENII DE APLICATIE

Constructii metalice;
Cazangerie inclusiv ind. chimica/petrolifera;
Sudarea tevilor;
Tinichigerie / instalatii.

MAIN APPLICATIONS

Metal working industry;
Vessels, boilers fabrication including the chemical industry;
Pipes fabrication;
Coachbuilders.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Cu				
0.06 - 0.14	0.90 - 1.30	0.50 - 0.80	≤ 0.025	≤ 0.025	≤ 0.035				

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d	Kv J -20°C	
Ar	Stare sudată/*As welded*	≥ 520	≥ 420	≥ 29	≥ 80	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000			
Tub/*Tube*	5 kg	W000283310	W000283311	W000283312	W000283313			

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

ALTIG SG2

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.18:	ER 70S-6
EN ISO 17632-A:	W 3 Si
DIN 8559:	WSG2

AUTORIZARI / ***APPROVALS***

TÜV (05671.06)
DB (42.098.25)

CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor carbon. Bune caracteristici mecanice si de tenacitate.
Destinata sudarii straturilor de radacina la tevi, fara perna de gaz.

MAIN FEATURES

Tig rod for non alloy steels welding. Good mechanical and toughness properties.
Suitable for root pass on pipe welding, without backing gas.

DOMENII DE APLICATIE

Constructii metalice;
Cazangerie inclusiv ind. chimica/petrolifera;
Sudarea tevilor;
Tinichigerie / instalatii.

MAIN APPLICATIONS

Metal working industry;
Vessels, boilers fabrication including the chemical industry;
Pipes fabrication;
Coachbuilders.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Cu				
0.06 - 0.14	1.30 - 1.85	0.50 - 0.80	≤ 0.025	≤ 0.025	≤ 0.035				

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d	Kv J -30°C	
Ar	Stare sudată/*As welded*	≥ 520	≥ 420	≥ 29	≥ 80	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000			
Tub/*Tube*	5 kg	W000283328	W000283329	W000283330	W000283331			

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

ALTIG Mo E

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.28-93:	ER 70S-A1
EN ISO 21952-A:	W Mo Si
EN 1668-97:	W2 Mo

AUTORIZARI / ***APPROVALS***

TÜV:	W2 Mo - W Mo Si

CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor slab aliate cu 0,5% Mo cu limita de curgere ridicata si rezistente la temperaturi ridicate.
Destinate sudarii straturilor de radacina la tevi, fara utilizarea unei perne de gaz.

MAIN FEATURES

Tig rod for low alloy high tensile steels and creep resistant steels of the 0,5% Mo type.
Suitable for root pass on pipe welding, without backing gas.

DOMENII DE APLICATIE

Cazangerie;
Industria chimica si petrochimica;
Sudarea tevilor.

MAIN APPLICATIONS

Vessels, boilers fabrication;
Chemical, petrochemical industry;
Pipes fabrication.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Mo				
0.08 - 0.12	0.70 - 1.30	0.50 - 0.70	≤ 0.020	≤ 0.020	0.40 - 0.60				

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d	Kv J -20°C	
Ar	Stare sudată/*As welded*	≥ 600	≥ 500	≥ 23	≥ 47	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000				
Tub/*Tube*	5 kg	W000283357	W000283358	W000283359				

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

ALTIG CrMo1E

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

EN ISO 21952-A:	W CrMo1Si

AUTORIZARI / ***APPROVALS***

TÜV:	W CrMo 1 Si

CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor slab aliate cu 1,25% Cr - 0,5% Mo rezistente la temperaturi inalte.
Destinate sudarii straturilor de radacina la tevi, fara perna de gaz.

MAIN FEATURES

Tig rod for low alloy creep resistant steels of the 1,25 %Cr - 0,5% Mo type. Suitable for root pass on pipe welding, without backing gas.

DOMENII DE APLICATIE

Cazangerie;
Industria chimica si petrochimica;
Sudarea tevilor.

MAIN APPLICATIONS

Vessels, boilers fabrication;
Chemical, petrochemical industry;
Pipes fabrication.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Mo	Cr	V	Cu	
0.08 - 0.14	0.80 - 1.20	0.50 - 0.80	≤ 0.020	≤ 0.020	0.40 - 0.60	0.90 - 1.30	≤ 0.030	≤ 0.30	

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d	Kv J +20°C	
Ar	Dupa/*After 620°C x 1h*	≥ 590	≥ 490	≥ 25	≥ 47	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000				
Tub/*Tube*	5 kg	W000283368	W000283369	W000283370				

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

ALTIG CrMo2E

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

EN ISO 21952-A: W Cr Mo 2 Si

AUTORIZARI / ***APPROVALS***

CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor slab aliate cu 2,25% Cr - 1% Mo rezistente la temperaturi inalte.
Destinate sudarii straturilor de radacina la tubulaturi. Este obligatorie protejarea radacinii cu gaz inert pentru a preveni oxidarea cromului.

MAIN FEATURES

Tig rod for low alloy creep resistant steels of the 2,25%Cr - 1% Mo type. Suitable for root pass on pipe welding. Its mandatory to use inert backing gas to avoid crome oxidation.

DOMENII DE APLICATIE

Cazangerie;
Industria chimica si petrochimica;
Fabricarea tevilor.

MAIN APPLICATIONS

Vessels, boilers fabrication;
Chemical, petrochemical industry;
Pipes fabrication.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Mo	Cr	V	Cu	
0.04 - 0.12	0.80 - 1.20	0.50 - 0.80	≤ 0.020	≤ 0.020	0.90 - 1.20	2.30 - 3.00	≤ 0.030	≤ 0.30	

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d	Kv J +20°C	
Ar	Dupa/*After 720°C x 1h*	≥ 650	≥ 570	≥ 22	≥ 47	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000				
Tub/*Tube*	5 kg	W000283374	W000283375	W000283376				

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

ALTIG CrMo5

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.28-93: ER 80S-B6
EN ISO 21952-A: W CrMo5Si

AUTORIZARI / ***APPROVALS***

TÜV (03295.05)

CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor aliate cu 5,00% Cr, 0,50% Mo rezistente la temperaturi inalte.
Destinate sudarii straturilor de radacina la tubulaturi. Este obligatorie protejarea radacinii cu gaz inert pentru a preveni oxidarea cromului. Se recomanda preincalzirea la 200-300°C inainte de sudare si mentinerea acestei temperaturi pe durata sudarii.

MAIN FEATURES

Tig rod for low alloy creep resistant steels of the 5,00%Cr, 0,50% Mo type. Suitable for root pass on pipe welding. Its mandatory to use inert backing gas to avoid crome oxidation. Preheating (200-300°C) of peace and interpass (200-300°C) are suggested.

DOMENII DE APLICATIE

Cazangerie;
Industria chimica si petrochimica.

MAIN APPLICATIONS

Vessels, boilers fabrication;
Chemical, petrochemical industry.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Mo	Cr	Cu		
0.03 - 0.10	0.40 - 0.70	0.20 - 0.50	≤ 0.020	≤ 0.020	0.50 - 0.65	5.50 - 6.50	≤ 0.30		

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d	Kv J +20°C	
Ar	Dupa/*After 745°C x 1h*	≥ 600	≥ 480	≥ 22	≥ 47	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000				
Tub/*Tube*	5 kg	W000283380	W000283381	W000283382				

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

ALTIG Ni 1

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.28-96: ER 80S-Ni1
EN 1668-97: W 46 6 W3 Ni1

AUTORIZARI / ***APPROVALS***

TÜV (03286.05)

CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor aliate cu 1% Ni si a otelurilor cu granulatie fina destinate a lucra la temperaturi scazute. Bune caracteristici mecanice si de tenacitate.
Destinata sudarii straturilor de radacina la tevi, fara perna de gaz. Recomandat pentru sudarea otelurilor de tip A 333 - 67, A 334 - 67 si a tevilor din otelurile X 56, X 60, X 65, X 70, X 80.

MAIN FEATURES

Tig rod for low alloy 1% Ni and fine grained steels for low temperature applications welding. Good mechanical and toughness properties.
Suitable for root pass on pipe welding, without backing gas. Suitable for welding A 333 - 67, A 334 - 67 steels and pipe X 56, X 60, X 65, X 70, X 80.

DOMENII DE APLICATIE

Constructii metalice;
Cazangerie inclusiv ind. chimica/petrolifera;
Sudarea tevilor;
Tinichigerie / instalatii.

MAIN APPLICATIONS

Metal working industry;
Vessels, boilers fabrication including the chemical industry;
Pipes fabrication;
Coachbuilders.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	Ni	Mo	S	P	Cr	V	Cu
0.06 - 0.12	1.00 - 1.25	0.50 - 0.80	0.80 - 1.10	≤ 0.15	≤ 0.020	≤ 0.020	≤ 0.15	≤ 0.03	≤ 0.35

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d	Kv J -60°C	
Ar	Stare sudată/*As welded*	≥ 550	≥ 470	≥ 20	≥ 27	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000				
Tub/*Tube*	5 kg	W000283396	W000283397	W000283398				

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

ALTIG 308 L

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.9-93:	ER 308 L
EN ISO 14343-A:	W 19 9 L

AUTORIZARI / ***APPROVALS***

TÜV (01151.04)
DB (43.098.06)

CARACTERISTICI PRINCIPALE

Baghete pentru sudarea TIG a otelurilor inoxidabile austenitice cu compozitie chimica similara, in mod deosebit pentru oteluri de tipul 304 si 304 L. Continutul scazut de carbon permite obtinerea de suduri cu rezistenta marita la coroziune intergranulara. Poate fi utilizat si pentru sudarea otelurilor stabilizate (AISI 321 - AISI 347) cu temperaturi de lucru inferioare la 400°C.

MAIN FEATURES

Tig rod for austenitic stainless steel welding with similar chemical composition, in particular type AISI 304 and 304 L. Low carbon reduces the possibility of intergranular corrosion. It may be used for welding stabilized steels (e.g. AISI 321 - AISI 347) with working temperatures not exceeding 400°C.

DOMENII DE APLICATIE

Constructii metalice;
Productia de automobile si electrocasnice;
Cazangerie inclusiv in ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including the chemical industry;
Pipes fabrication.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
≤ 0.03	1.00 - 2.50	0.30 - 0.60	≤ 0.03	≤ 0.03	19.5 - 22.0	9.0 - 11.0	≤ 0.75	≤ 0.75	

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rp 0.2 N/mm²	E % 5d	Kv J +20°C	Kv J -196°C
Ar	Stare sudată/*As welded*	≥ 580	≥ 420	≥ 35	≥ 200	≥ 47

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.2 x 1000	1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000		
Tub/*Tube*	5 kg	W000283419	W000283420	W000283421	W000283422	W000283423		

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

ALTIG 309 L

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.9-93:	ER 309 L
EN ISO 14343-A:	W 23 12 L

AUTORIZARI / ***APPROVALS***

TÜV (05919.03)

CARACTERISTICI PRINCIPALE

Baghete TIG pentru sudarea otelurilor inoxidabile cu compozitie chimica similara si pentru sudarea imbinarilor eterogene dintre oteluri carbon si oteluri inoxidabile. Continutul scazut de carbon permite obtinerea de suduri rezistente la coroziune intergranulara. Pot fi utilizate pentru depuneri de straturi tampon inainte de depunerea straturilor tip 304 sau 304L.

MAIN FEATURES

TIG rod for welding of austenitic stainless steel of similar composition and for different material welding with difficult weldability like carbon steel with stainless steel. The low carbon content allows to obtain welding resistent to intergranular corrosion. It can be used as buffer layer on carbon steel before welding with stainless steels type 304 and 304 L.

DOMENII DE APLICATIE

Constructii metalice;
Productia de automobile si electrocasnice;
Cazangerie inclusiv in ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including the chemical industry;
Pipes fabrication.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
≤ 0.03	1.00 - 2.50	0.30 - 0.65	≤ 0.03	≤ 0.03	23.0 - 25.0	12.0 - 14.0	≤ 0.75	≤ 0.75	

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d	Kv J +20°C	
Ar	Stare sudată/*As welded*	≥ 520	≥ 420	≥ 35	≥ 47	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000			
Tub/*Tube*	5 kg	W000283480	W000283481	W000283482	W000283483			

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

ALTIG 310

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.9-93: ER 310
EN ISO 14343-A: W 25 20

AUTORIZARI / ***APPROVALS***

CARACTERISTICI PRINCIPALE

Baghete TIG pentru sudarea otelurilor inoxidabile cu compozitie chimica similara. Buna rezistenta la coroziune la temperatura ridicata (pana la 1100° C). Se folosesc pentru straturi de acoperire a otelurilor carbon si slab aliate, atunci cand compozitii chimice tip 25%Cr - 20%Ni sunt cerute. Corespunzător de asemenea pentru aplicatii la temperaturi ridicate *(~1000° C)* in medii sulfuroase, atmostera oxidanta sau reducatoare.

MAIN FEATURES

TIG rod for welding of stainless steel with similar chemical composition, designed for Ar shielding gas. Good resistance to corrosion also at high temperature application (up to 1100° C). Especially suitable for bead surface on carbon steels and low allowed steels, when 25%Cr - 20%Ni are required. Suitable also for high temperature works (~1000° C) and where solforous, oxiding or reducing atmosphere.

DOMENII DE APLICATIE

Constructii metalice;
Productia de automobile si electrocasnice;
Cazangerie inclusiv pentru ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for chemical industry;
Pipes fabrication.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
0.08 - 0.15	1.00 - 2.50	0.30 - 0.65	≤ 0.03	≤ 0.03	25.0 - 28.0	20.0 - 22.5	≤ 0.75	≤ 0.75	

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rp 0.2 N/mm²	E % 5d	Kv J +20°C	
Ar	Stare sudată/*As welded*	≥ 520	≥ 420	≥ 35	≥ 47	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000			
Tub/*Tube*	5 kg	W000283494	W000283495	W000283496	W000283497			

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

ALTIG 316 L

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.9-93:	ER 316 L
EN ISO 14343-A:	W 19 12 3 L

AUTORIZARI / ***APPROVALS***

TÜV:	SG X2CrNiMo 19 12

CARACTERISTICI PRINCIPALE

Baghete TIG pentru sudarea otelurilor inoxidabile cu continut scazut de carbon de tip AISI 316 sau similare stabilizate. Remarcabila pentru rezistenta mare la coroziune intergranulara si pentru rezistenta pana la temperaturi de 400°C.

MAIN FEATURES

TIG rod with low carbon content for welding of AISI 316 stainless steels and similars and/or stabilized steels. Good resistance to the intergranular corrosion Suitable for welding at temperature up to 400° C.

DOMENII DE APLICATIE

Constructii metalice;
Productia de automobile si electrocasnice;
Cazangerie inclusiv pentru ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for chemical industry;
Pipes fabrication.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
≤ 0.025	1.00 - 2.00	0.30 - 0.65	≤ 0.02	≤ 0.03	18.0 - 20.0	11.0 - 13.0	2.50 - 3.00	≤ 0.75	

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rp 0.2 N/mm²	E % 5d	Kv J +20°C	
Ar	Stare sudată/*As welded*	≥ 550	≥ 380	≥ 25	≥ 47	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.2 x 1000	1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000		
Tub/*Tube*	5 kg	W000283455	W000283456	W000283457	W000283458	W000283459		

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

ALTIG 347

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.9-93:	ER 347
EN ISO 14343-A:	W 19 9 Nb

AUTORIZARI / ***APPROVALS***

TÜV (02405.04)

CARACTERISTICI PRINCIPALE

Baghete TIG cu compozitie chimica 20 Cr - 10 Ni stabilizate cu niobiu. Corespunzatoare pentru sudarea otelurilor inoxidabile stabilizate cu titan sau niobiu, tip AISI 347 si AISI 321. Continutul de Nb creste rezistenta la coroziune intergranulara. Poate fi folosita pentru aplicatii la temperaturi ce depasesc 400°C.

MAIN FEATURES

TIG rod with 20 Cr-10 Ni content, niobium stabilized. Suitable for stainless steels titanium or niobium stabilized, like AISI 347 and AISI 321 The Nb content increase the resistance to the intergranular corrosion. Fit for welding with temperature exceeding 400°C.

DOMENII DE APLICATIE

Constructii metalice;
Productia de automobile si electrocasnice;
Cazangerie inclusiv pentru ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for chemical industry;
Pipes fabrication.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / *ROD CHEMICAL ANALYSIS %*

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
≤ 0.08	1.00 - 2.50	0.30 - 0.65	≤ 0.03	≤ 0.03	12.5 - 19.0	9.0 - 11.0	≤ 0.75	≤ 0.75	10x%C÷1%

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rp 0.2 N/mm²	E % 5d	Kv J +20°C	
Ar	Stare sudată/*As welded*	≥ 550	≥ 400	≥ 30	≥ 47	

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000			
Tub/*Tube*	5 kg	W000283438	W000283439	W000283440	W000283441			

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

LEXAL 22.9.3 N

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / *STANDARDS*

AWS A5.9: ER 2209
EN ISO 14343-A: W 22 9 3 NL

AUTORIZARI / *APPROVALS*

CARACTERISTICI PRINCIPALE

Baghete Tig pentru sudarea otelurilor inoxidabile Duplex. Bune caracteristici mecanice pana la (-50°C). Aceasta bagheta poate fi utilizata cu gaze de protectie ce contin azot (ARCAL 39), ce compenseaza pierderea de azot din baia de metal topit si asigura o buna rezistenta la coroziune.

MAIN FEATURES

Welding rod for GTAW process for Duplex steinless steels. Good mechanical characteristics down to -50°C. This rod could use a specific nitrogen gas (ARCAL 39) which compensates for the loss of nitrogen from the weld pool and ensures a better corrosion resistance.

DOMENII DE APLICATIE

Santiere navale;
Cazangerii (inclusiv pentru industria chimica si petrochimica);
Fabricatie tevi;
Constructii off-shore.

MAIN APPLICATIONS

Shipbuilding;
Vessels, boilers fabrication (including for chemical and petrochemical industry);
Pipes fabrication;
Off-shore fabrication.

POZITII DE SUDARE / *WELDING POSITIONS*

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

CURENT / *CURRENT:* DC-
GAZ / *GAS:* Ar (I1) EN 439
Ar + N (ARCAL 39)

ANALIZA CHIMICA A BAGHETEI % / *ROD CHEMICAL ANALYSIS %*

C	Mn	Si	S	P	Ni	Cr	Mo	N	Fe% Vol.
≤ 0.03	0.50 - 2.00	≤ 0.90	≤ 0.030	≤ 0.030	7.50 - 9.50	21.5 - 23.5	2.50 - 3.50	0.08 - 0.20	30 - 65

CARACTERISTICI MECANICE / *MECHANICAL PROPERTIES*

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d	Kv J +20°C	
Ar	Stare sudată/*As welded*	810	700	34	210	
Pitting Corrosion Test (conform ASTM G48 Metoda A / conditii testare: 24h la 20°C)						

AMBALARE STANDARD / *STANDARD PACKING*

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		2.0 x 1000	2.4 x 1000					
Tub/*Tube*	5 kg	W000283524	W000283525					

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

ALIN W 70/30

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.14 -89: ER Ni Cu-7

AUTORIZARI / ***APPROVALS***

CARACTERISTICI PRINCIPALE

Baghete Tig pentru sudarea aliajelor nichel/cupru tip: *ASME B127, B163, B164, B165.* Bune caracteristici mecanice si de sudabilitate. Buna rezistenta la coroziune in apa de mare si medii acide (sulfuric, clorhidric, fosforic, ...). Proprietatile mecanice sunt garantate pana la 450° C. Materialul contine suficient titan pentru a controla formarea porilor in timpul procesului de sudare.

MAIN FEATURES

Road for GTAW welding of nickel/copper alloys type: ASME B127, B163, B164, B165. Good mechanical properties and weldability. Good resistance to sea corrosion and acid corrosion (solphoric, cloride, phosphoric, ...). This metal maintaine good properties til 450°C. The filler metal contains sufficient titanium to control porosities in welding process.

DOMENII DE APLICATIE

Vase sub presiune, cazangerii (inclusiv pentru industria chimica si petrochimica);
Fabricatie tevi;
Constructii off-shore;
Placari.

MAIN APPLICATIONS

Vessels, boilers fabrication (including for chemical and petrochemical industry);
Pipes fabrication;
Off-shore fabrication;
Cladding.

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

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

CURENT / ***CURENT:*** DC-

GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Mn	Si	S	P	Cu	Fe	Ni	Al	Ti
≤ 0.15	≤ 4.0	≤ 1.25	≤ 0.015	≤ 0.020	REM	≤ 2.5	62 - 69	≤ 1.25	1.5 - 3.0

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d		
Ar	Stare sudată/*As welded*	≥ 500	≥ 360	≥ 30		

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		2.0 x 1000	2.4 x 1000					
Tub/*Tube*	5 kg	W000283552	W000283553					

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

ALIN 82

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.14-89: ER Ni Cr-3

AUTORIZARI / *APPROVALS*

TÜV (07204.03)

CARACTERISTICI PRINCIPALE

Baghete Tig pentru sudarea aliajelor nichel/cupru tip: UNS N06600 (ASTM B163, B166, B167, B168). Recomandate pentru imbinari eterogene intre aliaje de nichel si otel sau intre oteluri inoxidabile si oteluri carbon. Utilizate adesea pentru placarea otelurilor carbon si slab aliate. Buna rezistenta la coroziune pana la 450°C in aer.

MAIN FEATURES

Road for GTAW welding of nickel-chromium-iron alloys type: UNS N06600 (ASTM B163, B166, B167, B168). Suitable for dissimilar joints between nickel alloys and steels or stainless steels and carbon steels. Used ofen for cladding of carbon and low alloy steels. Good corrosion resistance til 450°C in air.

DOMENII DE APLICATIE

Vase sub presiune, cazangerii(inclusiv pentru industria chimica si petrochimica);
Fabricatie tevi;
Constructii off-shore;
Placari.

MAIN APPLICATIONS

Vessels, boilers fabrication (including for chemical and petrochemical industry);
Pipes fabrication;
Off-shore fabrication;
Cladding.

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 (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / *ROD CHEMICAL ANALYSIS %*

C	Mn	Si	S	P	Cr	Fe	Ni	Nb + Ta	Ti
≤ 0.10	2.5 - 3.5	≤ 0.50	≤ 0.015	≤ 0.030	18.0 - 22.0	≤ 3.0	≥ 67	2.0 - 3.0	≤ 0.75

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d		
Ar	Stare sudată/*As welded*	≥ 600	≥ 360	≥ 25		

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		2.0 x 1000	2.4 x 1000					
Tub/*Tube*	5 kg	W000283541	W000283542					

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

ALIN 625

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.14-89: ER NiCrMo-3

AUTORIZARI / ***APPROVALS***

TÜV (07202.03)

CARACTERISTICI PRINCIPALE

Baghete Tig pentru sudarea aliajelor nichel-crom-molibden tip: UNS N06625 (*ASME B443, B444, B446).* Recomandate pentru imbinari eterogene intre aliaje de nichel si oteluri sau intre diferite aliaje de nichel. Proprietatile mecanice sunt garantate intre -195°C si 1100°C. Excelenta rezistenta la coroziune tip pitting si coroziune fisuranta sub tensiune. Buna rezistenta in medii de acizi minerali si organici.

MAIN FEATURES

Road for GTAW welding of nickel-chromium-molibdeum alloys type: UNS N06625 (ASTM B443, B444, B446). Suitable for dissimilar joints between nickel alloys and steels or different nickel alloys. Suitable for design temperatures from -196°C to 1100°C. Excellent resistance to pitting corrosion and tenso-corrosion. Good resistance to many types of mineral and organic acid.

DOMENII DE APLICATIE

Vase sub presiune, cazangerii(inclusiv pentru industria chimica si petrochimica);
Fabricatie tevi;
Constructii off-shore;
Placari.

MAIN APPLICATIONS

Vessels, boilers fabrication (including for chemical and petrochemical industry);
Pipes fabrication;
Off-shore fabrication;
Cladding.

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

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

CURENT / ***CURRENT:*** DC-

GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / *ROD CHEMICAL ANALYSIS %*

C	Mn	Si	S	P	Cr	Fe	Ni	Nb + Ta	Mo
≥ 0.10	≤ 0.50	≤ 0.50	≤ 0.015	≤ 0.020	22.0 - 23.0	≤ 5.0	≥ 58	3.15 - 4.15	8.0 - 10.0

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rs N/mm²	E % 5d		
Ar	Stare sudată/*As welded*	≥ 760	≥ 500	≥ 25		

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000				
Tub/*Tube*	5 kg	W000283547	W000283548	W000283549				

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

ALTIG Cu

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.7:	ER Cu
DIN 1733:	SG-CuSn

AUTORIZARI / ***APPROVALS***

CARACTERISTICI PRINCIPALE

Baghete Tig pentru sudarea cuprului si aliajelor de cupru. Buna umectare. Utilizabile pentru acoperiri rezistente la uzare. Este necesara o preincalzire a materialului de baza pentru grosimi mai mari de 3 mm. Pot fi folosite si pentru sudarea oxiacetilenica. In acest caz se foloseste dezoxidantul DEOXID/CUPXITE.

MAIN FEATURES

TIG rod for welding of copper and copper alloys. Good sliding. Usable for wear-resistant surfacing.
Is necessary pre-heating the base material in case of thickness higher than 3 mm.
Suitable for oxyacetylene welding. In this case use deoxidisers DEOXID/CUPXITE.

DOMENII DE APLICATIE

Autovehicule, productia de autobuze si aplicatii electrice;
Placari;
Fabricatia de tevi.

MAIN APPLICATIONS

Car, bus production and electro-domestic application;
Surfacing;
Pipe fabrication.

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

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

CURENT / ***CURRENT:*** DC-
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

C	Sn	Mn	Si	P	Al	Pb			
≥ 98.0	≤ 1.00	≤ 0.50	≤ 0.50	≤ 0.15	≤ 0.01	≤ 0.02			

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	HB			
Ar	Stare sudată/*As welded*	210 - 245	60 - 80			

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		2.0 x 1000	2.4 x 1000					
Tub/*Tube*	5 kg	W000283604	W000283605					

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

ALTIG Al 99.5

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.10:	ER 1100
EN ISO 18273-A:	S Al 1070 (Al 99.7)
BS 2901 Pt4:	1050A

AUTORIZARI / ***APPROVALS***

TÜV (01489.03)

CARACTERISTICI PRINCIPALE

Baghete Tig pentru sudarea aluminiului si aliajelor de aluminiu cu pana la 0,5% elemente de aliere.
Recomandate pentru sudarea aliajelor tip 1050A si 1100.

MAIN FEATURES

TIG rod for welding of pure aluminium and its alloys up to maximum 0,5% alloying elements.
Suitable for welding of commercial alloys 1050A and 1100.

DOMENII DE APLICATIE

Prelucrarea metalelor.
Autovehicule, productia de autobuze si aplicatii electrice.

MAIN APPLICATIONS

Metal working industry.
Car; bus production and electro-domestic appliances.

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:*** AC
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

Al	Si	Fe	Cu	Mn	Mg	Zn	Ti		
≥ 99.5	≤ 0.30	≤ 0.40	≤ 0.40	≤ 0.05	≤ 0.05	≤ 0.07	≤ 0.05		

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rp 0.2 N/mm²	E % 5d		
Ar	Stare sudată/*As welded*	≥ 65	≥ 20	≥ 35		

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		2.0 x 1000	2.4 x 1000	3.2 x 1000				
Cutie/*Box*	5 kg	W000283556	W000283557	W000283558				

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

ALTIG Al Si5

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.10:	ER 4043
EN ISO 18273-A:	SG Al 4043 (Al Si5)
BS 2901 Pt4:	4043A

AUTORIZARI / ***APPROVALS***

CARACTERISTICI PRINCIPALE

Baghete Tig pentru sudarea aluminiului si aliajelor de aluminiu cu continut de siliciu pana la 7%. Recomandate pentru aliaje tip Al/Mg/Si serie 6000 si pentru imbinari eterogene intre 6000/1000 si 6000/3000. Inaltul continut de siliciu imbunatateste caracteristicile mecanice.

MAIN FEATURES

TIG rod for welding of aluminium and aluminium alloys with a silicon content up to 7%. Suitable for Al/Mg/Si alloys serie 6000 and for mixed welding like 6000/1000 and 6000/3000. The high silicon content improves the low characteristics.

DOMENII DE APLICATIE

Prelucrarea metalelor.
Autovehicule, productia de autobuze si aplicatii electrice.

MAIN APPLICATIONS

Metal working industry.
Car; bus production and electro-domestic appliances.

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

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

CURENT / ***CURRENT:*** AC
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

Al	Si	Fe	Mn	Mg	Zn	Ti			
≥ 93	4.50 - 5.50	≤ 0.40	≤ 0.05	≤ 0.05	≤ 0.10	≤ 0.15			

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rp 0.2 N/mm²	E % 5d		
Ar	Stare sudată/*As welded*	≥ 120	≥ 40	≥ 8		

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		2.0 x 1000	2.4 x 1000	3.2 x 1000				
Tub/*Tube*	5 kg	W000283563	W000283564	W000283565				

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

ALTIG Al Mg5

BAGHETE TIG / *GTAW TOD*

CLASIFICARE / ***STANDARDS***

AWS A5.10:	ER 5356
EN ISO 18273-A:	SG Al 5356 (Al Mg5 G)
BS 2901 Pt4:	5356

AUTORIZARI / ***APPROVALS***

TÜV (01491.05)
DB (61.098.04)

CARACTERISTICI PRINCIPALE

Baghete Tig pentru sudarea aluminiului si a aliajelor de aluminiu cu magneziu pana la 5%. Recomandate pentru sudarea structurilor metalice din aliaje de aluminiu comercial. Bune caracteristici mecanice si de inalta rezistenta la coroziune si chiar si la coroziune marina.

MAIN FEATURES

TIG rod for welding of aluminium and aluminium alloys with a manganese content up to 5%. Suitable for welding of all commercial aluminium alloys, also in structural works. Good mechanical properties and high resistance to corrosion as well marine corrosion.

DOMENII DE APLICATIE

Prelucrarea metalelor;
Industria feroviara si constructii civile;
Autovehicule, productia de autobuze si aplicatii electrice.

MAIN APPLICATIONS

Metal working industry;
Railways and civil works;
Car; bus production and electro-domestic appliances.

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

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

CURENT / ***CURRENT:*** AC
GAZ / ***GAS:*** Ar (I1) EN 439

ANALIZA CHIMICA A BAGHETEI % / ***ROD CHEMICAL ANALYSIS %***

Al	Si	Fe	Mn	Mg	Cu	Cr	Zn		
≥ 93	≤ 0.25	≤ 0.40	0.10 - 0.20	4.50 - 5.60	≤ 0.05	0.10 - 0.30	≤ 0.10		

CARACTERISTICI MECANICE / ***MECHANICAL PROPERTIES***

GAZ	**Tratament termic/*Heat treatment***	Rm N/mm²	Rp 0.2 N/mm²	E % 5d		
Ar	Stare sudată/*As welded*	≥ 240	≥ 110	≥ 17		

AMBALARE STANDARD / ***STANDARD PACKING***

Ambalare / *Packaging*	Greutate / *Weight*	Diametru mm x lungime mm / *Diameter mm x lenght mm*						
		1.6 x 1000	2.0 x 1000	2.4 x 1000	3.2 x 1000	4.0 x 1000		
Cutie/*Box*	5 kg	W000283587	W000283588	W000283589	W000283590	W000283591		

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