NST SF-1 A TÄYTELANKA ASENTO 1,2MM 5kg



Tuote	
Tuotekoodi:	SF1A-1.2/5
Viivakoodi:	9105000000003

Tekniset tiedot	
Paino:	1 kg

SF-1A

Laivojen ja rakenteiden yleiskäyttöinen täytelanka, jolla on iskutesti lämpötilassa -20 ° C.

AWS A5.20 E71T-1M
AWS A5.36 E71T1-M21A2-CS1
EN ISO 17632-A: T 42 2 ZMn P M21 1 H5
EN ISO 9606-1: FM1

SF-1A is a seamless rutile flux cored wire for welding with Argon/CO2 mixed shielding gas. Being seamless it provides welds with very low diffusible hydrogen content, typical 2.8ml/100g weld metal. The flux cored wire has excellent weldability in all positions and is extremely efficient in the root pass against ceramic backing. Good penetration in vertical down greatly reduces the risk of imperfections. It also gives excellent performance against porosity on primed steel plates when using automated welding such as a fillet welding tractor. SF-1A has a stable welding arc with less spatter and perfect bead surface. The flux cored wire has a clean, copper coated surface.

Together with exact diameter and roundness it provides a stable and even wire feeding. This reduces wear and tear of liners and contact tips. The wire is classified as a grade 3 (-20°C).

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu
0,05	0,41	1,36	0,010	0,008	0,26

Typical mechanical properties of all-weld-metal:

Yield	Tensile	Elongation	Charpy
530 Mpa	590 Mpa	28 %	95V(J)/-20°C

Diffusible hydrogen content:

≤5 ml/100g (2,8 ml/100g typical).