

NST SF-3 A TÄYTELANKA ASENTO 1,2MM 12,5kg



Tuote

Tuotekoodi:	SF3A-1.2/12.5
Viivakoodi:	5562000000008

Tekniset tiedot

Paino:	1 kg
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SF-3A

Rutiilitäytelanka hiiliteräksen hitsaamiseksi iskuvaatimuksilla -40° C asti.

AWS A5.20 E71T-9M-J
AWS A5.36 E71T1-M21A4-CS1
EN ISO 17632-A: T 46 4 ZMnNi P M21 1 H5
EN ISO 9606-1: FM1

SF-3A is a seamless, rutile flux cored wire designed for welding of steel with impact requirements down to -40°C such as grade E often used in shipbuilding. The flux cored wire uses a Argon/CO2 mixed shielding gas which gives good weldability and a stable arc, minimum spatter, good visual bead and even transition to parent material. Due to the seamless design the wire has an extremely low hydrogen content, (typical of ≤ 2.8 ml/100g) which greatly reduces the possibility of cold cracks. SF-3A emits little welding fume and has great weldability in all positions. The wire has a clean copper coated surface which together with exact diameter and roundness, ensures stable and

even wire feeding. Wire stick out should be between 15-25mm dependent upon the welding parameters. Voltage should be approx. 10% of the Ampere, which is 1-3 Volts lower than that of which conventional folded flux cored wires require.

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni
0,05	0,50	1,50	0,010	0,006	0,30	0,35

Typical mechanical properties of all-weld-metal:

Yield	Tensile	Elongation	Charpy
547 Mpa	612 Mpa	25 %	90V(J)/-40°C

Diffusible hydrogen content:

≤5 ml/100g (2,8 ml/100g typical).

