

	TECNHICAL DATA SHEET	FT-DQ40
	EUROTROD LC 24	PÁG. 1/1

CLASSIFICATION:

AWS A5.4: E 308L-17
ISO 3581-A- E 19 9 LR 12

CERTIFIED COMPANY:



Management System
ISO 9001:2015

www.tuv.com
ID 1100008183



DESCRIPTION:

Rutile high-alloy extra-low carbon electrode (ELC) for non-stabilized and stabilized chromium-nickel steels 18 Cr/10 Ni type with Titanium or Niobium. Excellent welding (AC/DC), smooth running. Good striking and restriking. Regular appearance, finely rippled, smooth junction. Easy slag removal. The arc is "spray" type giving a finely rippled appearance having the tendency to be concave in positions.

SUITABLE FOR:

AISI 302, 304, 304 L, 308, 308 L	AISI 321, 347		
W Nr 1.4541, 1.4550, 1.4552	W Nr 1.4306, 1.4311		
W Nr 1.4301, 1.4303, 1.4308	W Nr 1.4310, 1.4319		

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

C	Si	Mn	Cr	Ni			
< 0,03	0,80	0,55	18,5	10,5			

Mechanical Properties:


Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)	CHARPY V (J)	
			+20 °C	
>350	>520	>35	>50	

PRODUCT INFORMATION:

WELDING PARAMETERS				PACKING DATA	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (kg)
1,6	300	25 – 30	AC/DC	210	1,6
2,0	300	30 – 50	AC/DC	145	1,8
2,5	300	50 – 75	AC/DC	100	1,8
3,2	350	75 – 110	AC/DC	55	2,0
4,0	350	110 – 150	AC/DC	35	2,0

APPROVALS :

VdTuv
DB


 0035
15
0035-CPR-C639
EN 13479 + ISO 3581-A

WELDING POSITIONS:

