

	<b>TECNHICAL DATA SHEET</b>	FT-DQ43
	<b>EUROTROD LC 28</b>	PÁG. 1/1

**CLASSIFICATION:**

AWS A5.4: E 316L-17  
ISO 3581-A-E 19 12 3 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/12 Ni/2 Mo 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:**

W Nr 1.4404, 1.4406, 1.4429	AISI 316 Ti, 318		
W Nr 1.4401, 1.4408, 1.4435	AISI 316, 316 L		
W Nr 1.4571, 1.4580, 1.4581, 1.4583	W Nr 1.4436		

**TYPICAL CHARACTERISTICS OF ALL-WELD METAL:**
**Chemical Analysis (%):**

C	Si	Mn	Cr	Ni	Mo		
< 0,03	0,80	0,55	18,0	12,0	2,20		

**Mechanical Properties:**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation 5d (%)		
>350	>520	>30		

**PRODUCT INFORMATION:**

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Intensidade Corrente (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

**CE**

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

**WELDING POSITIONS:**
