	TECNHICAL DATA SHEET	FT-DQ57
	EUROTROD LC 52	PÁG. 1/1

CLASSIFICATION:

AWS A5.4: E 309 L 16
ISO 3581-A-E 23 12 L R

CERTIFIED COMPANY:



Management System
ISO 9001:2015

www.tuv.com
ID 1100008183



DESCRIPTION:

Rutile high-alloy extra-low carbon electrode (ELC) for chromium-nickel steels type 23 Cr/13 Ni and dissimilar joining of carbon steels to stainless steel. Also suitable as a buffer layer. Smooth running. Good striking and restriking. Regular appearance, finely rippled, smooth junction. Easy slag removal.

SUITABLE FOR:

AISI 309, 309 L	All chromium-nickel steels with low or medium C content, as well as titanium or Niobium stabilized stainless steels.

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

C	Si	Mn	Cr	Ni			
< 0,03	0,85	0,70	24,0	13,0			

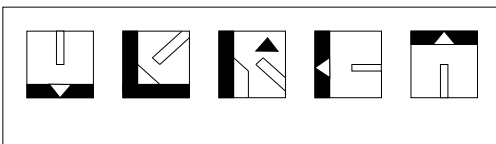
Mechanical Properties:


Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)	CHARPY V (J)	
			+ 20 °C	
>460	>600	>32	>40	

PRODUCT INFORMATION:

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (Kg)
2,0	300	30 – 50	AC/DC	155	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

WELDING POSITIONS:





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1328-CPR-0371
EN 13479 + ISO 3581-A-E 23 12 L R