

	TECNHICAL DATA SHEET	FT-DQ51
	EUROTROD LC 59	PÁG. 1/1

CLASSIFICATION:

AWS A5.4: ~ E 310-16
ISO 3581-A-E 25 20 R 12

CERTIFIED COMPANY:


Management System
ISO 9001:2015



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ID 1100008183

DESCRIPTION:

Rutile type electrode for 25 Cr – 20 Ni type, up to 1100 °C.

SUITABLE FOR:

-Refractory Steels:
AISI 309, 310, 310S,
DIN X15Cr NiSi 2520,
X12CrNi 2521, X15CrNiSi2012

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

C	Si	Mn	Cr	Ni			
0,10	0,85	1,20	25,0	20,0			

Mechanical Properties:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)
>350	>550	>20

PRODUCT INFORMATION:

WELDING PARAMETERS				PACKING DATA	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (kg)
2,5	300	55 – 80	AC/DC	100	1,8
3,2	350	70 – 110	AC/DC	55	2,0
4,0	350	110 – 155	AC/DC	40	2,0

WELDING POSITIONS:
