ELECTRO PORTUGAL	TECNHICAL DATA SHEET	FT-DQ52
	EUROTROD LC 62	PÁG. 1/1

CLASSIFICATION:

AWS A5.4: E 2209-17
EN ISO 3581-A:E22 9 3 N L R 12

CERTIFIED COMPANY:

TÜVRheinland CERTIFIED
Management System ISO 9001:2015
www.tuv.com ID 1100008183

DESCRIPTION:

Rutile high-alloy extra-low carbon electrode (ELC) for duplex steels. Excellent welding (AC/DC), smooth running. Good striking and restriking. Regular appearance, finely rippled, smooth junction. Easy slag removal.

SUITABLE FOR:

X2 CrNiMoN 22 -5-3 1.4462			
X3 CrNiMoN 27-5-2 1.4460			
X2 CrNiN 23-4 1.4362			

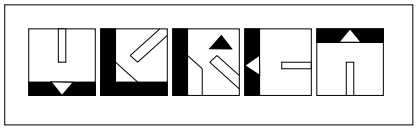
TYPICAL CHARACTERISTICS OF ALL-WELD METAL:
Chemical Analysis (%):

C	Si	Mn	Cr	Ni	Mo	N	
<0,03	0,90	0,65	22,0	9,0	3,0	0,14	

Mechanical Properties:

Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation 5d (%)	CHARPY V (J)		
			+20 °C	-40 °C	-60 °C
>600	>750	>20	>50	>35	>32

PRODUCT INFORMATION:

WELDING PARAMETERS				VACUUM PACKING	
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
4,0	450	110 – 150	AC/DC	80	5,5

WELDING POSITIONS: