

	<b>TECNHICAL DATA SHEET</b>	FT-DQ61
	<b>EUROTROD LR 47</b>	PÁG. 1/1

**CLASSIFICATION:**

AWS A5.4: ~ E 307-16  
ISO 3581-A- 18 8 Mn R 12

**CERTIFIED COMPANY:**

	Management System ISO 9001:2015  www.tuv.com ID 1100008183	
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**DESCRIPTION:**

Rutile type electrode, particularly suitable for difficult weld steels, manganese-alloyed steels, joining dissimilar steels. Suitable as a buffer layer when hard facing and as pure hard facing of parts subject to extreme impact conditions.

**SUITABLE FOR:**

Difficult weld steels, e.g. unalloyed and high-strength alloy steels, carbon steels, high-alloy steels, tool steels, heat treating steels, spring steels, rail steels, manganese hardening steels.

**TYPICAL CHARACTERISTICS OF ALL-WELD METAL:**

**Chemical Analysis (%):**

C	Si	Mn	Cr	Ni			
0,11	1,10	4,60	19,0	9,0			

**Mechanical Properties:**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation 5d (%)	Hardness HB > 200 Considerable increase in hardness to 450 HB as a result of cold forming
>350	>500	>25	

**PRODUCT INFORMATION:**

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (Kg)
2,5	300	50 – 70	AC/DC	110	1,8
3,2	350	95 – 120	AC/DC	65	2,0
4,0	350	120 – 160	AC/DC	40	2,0
5,0	350	160 – 200	AC/DC	27	2,0

**WELDING POSITIONS:**

