

	<b>TECNHICAL DATA SHEET</b>	FT-DQ64
	<b>EUROTROD LR 82</b>	PÁG. 1/1

**CLASSIFICATION:**

AWS A5.11: E Ni Cr Fe-3

**CERTIFIED COMPANY:**

**DESCRIPTION:**

Basic covering electrode for the welding of Ni, Ni-Cr alloys, heterogeneous welding and difficult weld steels.

**SUITABLE FOR:**

Inconel		
Nimonic		
Heat resistant steels		
Steels for cryogenic applications		

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

C	Si	Mn	Cr	Fe	Nb	Ni	
0,04	0,4	7,5	16	7	2	Balance	

**Mechanical Properties:**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation 4d (%)		
>390	>550	>30		

**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	75 – 100	DC	80	2,0
3,2	350	100 – 140	DC	48	2,3
4,0	350	140 – 180	DC	30	2,1

**WELDING POSITIONS:**
