

TECHNICAL DESCRIPTION

EUROTROD LR 35

CERTIFIED COMPANY:



APCER
CERTIFICADO
N. 2000/CEP. 1272
SISTEMA PORTUGUÊS
DA QUALIDADE
NP EN ISO 9001



CLASSIFICATION:

AWS A5.4: ~E 312-16
EN 1600: E 29 9 R 12

DESCRIPTION:

Rutile type electrode for high-alloy and unalloyed steels. Good for all-position weldability, except vertical-downward.

SUITABLE FOR:

AISI 312	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	1,0	0,65	28,5	10,0			

Mechanical Properties:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)		
>450	>660	>19		

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 – 75	AC/DC	105	1,8
3,2	350	75 – 110	AC/DC	55	2,0
4,0	350	110 – 150	AC/DC	45	2,2
5,0	350	140 – 190	AC/DC	25	1,8

WELDING POSITIONS:

