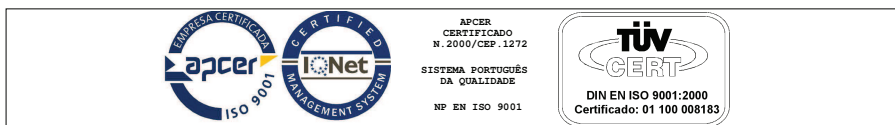


|   |                              |             |
|---|------------------------------|-------------|
|  | <b>TECHNICAL DESCRIPTION</b> | FT-DT.17.05 |
|   | <b>EUROTROD LR 35</b>        | PAGE 54/54  |

**CERTIFIED COMPANY:**



**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<br>(N/mm <sup>2</sup> ) | Tensile Strength<br>(N/mm <sup>2</sup> ) | Elongation<br>5d (%) |  |  |
|--|--|----------------------|--|--|
| >450                                   | >660                                     | >19                  |  |  |

**PRODUCT INFORMATION:**

| WELDING PARAMETERS |                |                            |                          | VACUUM PACKING         |                        |
|--------------------|----------------|----------------------------|--------------------------|------------------------|------------------------|
| Diameter<br>(mm)   | Length<br>(mm) | Recommended Current<br>(A) | Current Type<br>(Pole +) | Pieces /Packet<br>(Un) | Weight /Packet<br>(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:**

