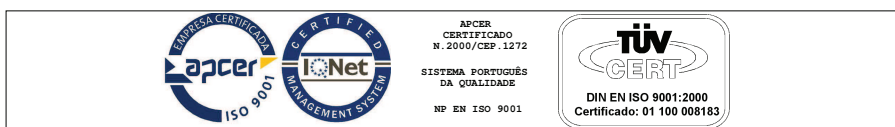


	TECHNICAL DESCRIPTION	FT-DT.15.07
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CERTIFIED COMPANY:



CLASSIFICATION:

AWS A5.4: E 316L-16
EN 1600: E 19 12 3 LR 12

DESCRIPTION:

Rutile high-alloy extra-low carbon electrode (ELC) for non-stabilized and stabilized chromium-nickel steels 18 Cr/12 Ni/2 Mo type with Titanium or Niobium. Excellent welding (AC/DC), smooth running. Good striking and restriking. Regular appearance, finely rippled, smooth junction. Easy slag removal.

SUITABLE FOR:

W Nr 1.4404, 1.4406, 1.4429	AISI 316 Ti, 318		
W Nr 1.4401, 1.4408, 1.4435	AISI 316, 316 L		
W Nr 1.4571, 1.4580, 1.4581, 1.4583	W Nr 1.4436		

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

C	Si	Mn	Cr	Ni	Mo		
< 0,03	0,75	0,55	18,0	12,0	2,55		

Mechanical Properties:

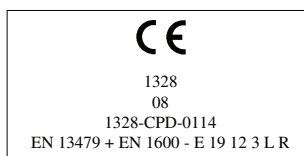
Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)	
>350	>520	>30	

PRODUCT INFORMATION:

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Intensidade Corrente (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

APPROVALS:

- I.S.Q. (Welding Institute of Quality): Cert. Nº 09/1300
 - Bureau Veritas / Rinave: Cert. Nº 09.L.2453



WELDING POSITIONS:

