

**Електроди Esab заваръчни 2.5x300 мм, 0.7 кг, 90 А,
неръждаеми, ОК 63.85**



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OK 63.85

Classifications	Approvals		Typical all weld metal composition, %		Typical mech. properties all weld metal	
<u>EN1600</u>	Sepros	UNA	C	<0,06	<u>Yieldstress.MPa</u>	
E 19 12 3 Nb B 4 2		VdTÜV	272580	Si	0,5	490
<u>SFA/AWSA5.4</u>		05662	Mn	1,7	640	
E 318-15			Cr	18,5	<u>Elongation.%</u>	
<u>WerkstoffNr.</u>			Ni	12,0	35	<u>Elongation.%</u>
1.4576			Mo	2,8	35	
			Nb	<1,0	<u>Ferritecontent</u>	
			Cu	<0,5	FN 5-10	
					<u>CharpyV</u>	
			Nb+		Test	Impact
			Ta	1,00	temps, °C	values, J
					+20	65
					-120	45
<u>Redrivingtemperature.°C</u>						
200						
<u>Redrivingtime.hours</u>						
2						
<u>Recovery</u>						
115						
Diameter, mm	2,5	3,2	4,0	5,0		
Length, mm	300	350	350	350		
Arc voltage, V	22	23	24	26		
Welding current, A	50-80	65-120	75-160	145-210		
N. Kg weld metal/kg electrodes	0,66	0,64	0,64	0,61		
B. No. of electrodes/kg weld metal	81	43	28	19		
H. Kg weld metal/hour arc time	1,0	1,5	2,0	2,7		
T. Burn-off time,	45	58	64	72		

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Категория: [Електродъгово заваряване](#)

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