

**Електроди Esab заваръчни 2x300 мм, 1.6 кг, 65 А,  
неръждаеми, ОК 63.30**



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SMAW

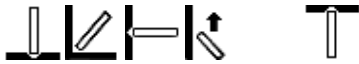
Type Acid-rutile

Extra low carbon stainless steel electrode for welding steels of the 18Cr 12Ni 2.8Mo-type.

Also suitable for welding of stabilized stainless steels of similar composition, except when the full creep resistance of the base metal is to be met.

Welding current

DC+, AC OCV 50 V



Classifications	Approvals		Typical all weld metal composition, %	Typical mech. properties all weld metal	
EN 1600	ABS	E316L-17	C <0,03	Yield stress, MPa	
E 19 12 3 LR 1 2	CWB	CSA	Si 0,75	460	
SFA/AWS A5.4		W48	Mn 0,9	Tensile strength, MPa	
E316L-17			Cr 18,0	570	
Werkstoff Nr.	DB	30.039.06	Ni 12,0	Elongation, %	
1.4430	DNV	316L	Mo 2,8	40	
CSA W48	GL	4571	Cu <0,2	Elongation, %	
E316L-17	LR	316L		40	
	Sepros	UNA		Ferrite content	
		272580		FN 3-10	
	VdTÜV	00262		Charpy V	
	CE	EN 13479		Test temps, °C Impact values, J	
	BV	316L		+20	60
				-20	55
				-60	43

Diameter, mm	1,6	2,0	2,5	3,2	4,0	5,0
Length, mm	300	300	300	350	350	350
Arc voltage, V	29	29	29	30	32	32
Welding current, A	30-45	45-65	45-90	60-125	70-190	100-280
N. Kg weld metal/kg electrodes	0,56	0,60	0,56	0,55	0,56	0,56
B. No. of electrodes/kg weld metal	250	147	96	52	34	21
H. Kg weld metal/hour arc time	0,4	0,6	1,1	1,4	2,0	3,0
T. Burn-off time, s/electrode	37	39	45	57	57	63

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Категория: [Електродъгово заваряване](#)

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