

**Електроди SIJ заваръчни 4x450 мм, 5.4 кг, 190 А, рутилови,
Емона**



Description and application:

Thick basic-rutile coated electrode for welding low alloyed steels with tensile strength up to 510 N/mm². The weld metal deposit has high mechanical properties and can be used for a wide range of materials.

Base materials:

	DIN:	W.Nr.:
Unalloyed steels:	St 33 to St 52.3	1.0035 to 1.0570
Boiler plates:	H1, H11, 17Mn4	1.0345, 1.0435, 1.0481
Pipe steels:	St 35 to St 52.4	1.0308 to 1.0581
	StE 210.7 to StE 360.7	1.0307 to 1.0582
Shipbuilding plates:	A, B, D, E	1.0440 to 1.0476
Steel castings:	GS-38 to GS-52	1.0416 to 1.0551
Finegrained steels	StE 255 to StE 355	1.0461 to 1.0562

Coating type:
Basic-rutile

Welding current:
AC
DC -

Welding positions:



Redrying temperature:
140 C / 1 h

Typical all weld metal properties:

Chemical composition, wt %:

	C	Si	Mn
	0.10	0.20	0.55

Mechanical properties:			
Yield strength	R _{eL} / R _{p 0.2}	> 360	MPa (N/mm ²)
Tensile strength	R _m	450 - 540	MPa (N/mm ²)
Elongation	A5:	> 24	%
Impact energy	KV:	> 47	J (-20 C)

Welding and packing data:

Approvals:	
CR:	3
ABS:	3
BV:	3
GL:	3
LR:	3
DNV:	3
RS:	3
TÜV	
SŽ	
PRS:	3
SZU	

Welding parameters			Packing		
mm	Length mm	Current A	Weight/ packet kg	Weight/ carton kg	Weight/ 1000 pcs kg *
2	300	55 – 70	4	20	11
2.5	300	70 – 90	4	20	17.1
3.25	350	115 – 145	4.4	22	32.8
4	450	145 – 190	6	30	62.5
5	450	200 – 250	6	30	98.4
6	450	250 - 290	6	30	142.9

* approximate data

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