

	TECNICAL DATA SHEET	FT-DQ24
	EUROTROD MF 29	PÁG. 1/1

CLASSIFICATION:

AWS A5.5: E 8018-B2 H4
ISO 3580-A-E CrMo 1 B 4 2 H5

CERTIFIED COMPANY:


Management
System
ISO 9001:2015
www.tuv.com
ID 1100008183


DESCRIPTION:

Basic type electrode for creep resisting steels and cast steels with similar composition up to 530 °C. Good weld ability in all positions. Low spatter loss, good bead appearance. Ready striking and deslagging.

SUITABLE FOR:

13 Cr Mo 4 4, 16 Cr Mo 4 4, 22 Cr Mo 4 4	15 Cr 3, 16 Mn Cr 5, 20 Mn Cr 5	
15 Cr Mo 5, 24 Cr Mo 5		
GS-25 Cr Mo 5 5, GS-22 Cr Mo 5 4		

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:
Chemical Analysis (%):

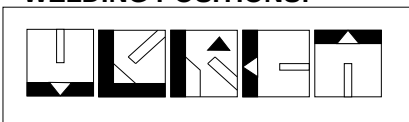
C	Si	Mn	Cr	Mo	P	S	
0,07	0,55	0,65	1,20	0,50	<0,02	<0,02	

Mechanical Properties (after heat treatment):

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)		
>480	>550	>20		

PRODUCT INFORMATION:

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (kg)
2,5	350	65 – 90	DC	85	1,9
3,2	350	90 – 130	DC	55	1,9
4,0	350	140 – 180	DC	40	2,0
5,0	450	190 – 230	DC	25	3,2

WELDING POSITIONS:


CE

0035
15

0035-CPR-C639
EN 13479 + ISO 2560-A

OBSERVATIONS:

Observe specifications on preheating and post-weld heat treatment of base materials.

