

	TECNHICAL DATA SHEET	FT-DQ64
	EUROTROD LR 82	PÁG. 1/1

CLASSIFICATION:

AWS A5.11: E Ni Cr Fe-3

CERTIFIED COMPANY:

DESCRIPTION:

Basic covering electrode for the welding of Ni, Ni-Cr alloys, heterogeneous welding and difficult weld steels.

SUITABLE FOR:

Inconel		
Nimonic		
Heat resistant steels		
Steels for cryogenic applications		

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

C	Si	Mn	Cr	Fe	Nb	Ni	
0,04	0,4	7,5	16	7	2	Balance	

Mechanical Properties:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 4d (%)	
>390	>550	>30	

PRODUCT INFORMATION:

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (kg)
2,5	300	75 – 100	DC	80	2,0
3,2	350	100 – 140	DC	48	2,3
4,0	350	140 – 180	DC	30	2,1

WELDING POSITIONS:
