

RUTWELD Mo

Electrodes MMA [SMAW]

Creep resistant steels

CLASSIFICATION: EN ISO 3580-A : E 46 Mo R 12 DIN 8575 : E MoR22 AWS A-5.5 : E 7013-G	APPROVALS: UDT	APPLICATION: Power generation industry Constructions & Engineering Metallurgy (Steelworks)
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Рутитовый электрод с добавлением Мо для сварки сталей, стойких к ползучести, работающих при температуре до 500°C.

Base material

DIN	W.Nr.	ISO	GOST-R
St 37 do St 52	1.0037 do 1.0570		17G1S
17Mn4	1.0426	P295GH	
19Mn6	1.0473	P355GH, PH29	
15Mo3	1.5415	16Mo3, F26	
St 35.8	1.0345	P235GH	12k
St45-8	1.0425	P265GH, F9	16k, 20k
WStE 355	1.0565	P255NH do P355NH	
St35-8	1.0305		
St52-3	1.0570	S355D	17G1S, 17GS
St50-2	1.0050	Fe490	St5ps, St5sp
St45.8	1.0405	P255G1TH	
StE 415.7	1.8972	L320 do L355NB	
StE 415.7 TM	1.8973	L320MB do L355MB	
16Mo3	1.5415	16Mo3, F26	
17Mn4	1.0481	P295GH, PT490	
	1.0562	P255 do P355N	15GF

Typical chemical composition %

C	Si	Mn	Cr	Mo	V	P	S
0,10	0,80	0,4-1,5	0,2	0,4-0,7	0.03	0,030	0,025

Typical mechanical properties

Yield strength Re [N/mm²]	>460
Tensile strength Rm [N/mm²]	530-680
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (20°C) /
Coating type	рутитовый
Welding current	



Welding positions

120°C / 1h

Welding parameters and packing

Ø	Длина [мм]	Ток сварки [А]	Вес пачки [кг]	Вес коробки [кг]
2,5	350 /	70-95	4,5	13,5
3,2	350 /	115-145	4,0	12,0
4,0	450 /	145-190		
5,0	450 /	200-240		

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