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Topnik aglomerowany do pracy wysokimi nat?eniami pr_du spawania, przy wymaganej dobrej udarnoúci do -50°C. Wytwarza atwo usuwalny uel, take w w_skich z_czach na V, zalecany do stali konstrukcyjnych, drobnoziarnistych i mrozoodpornych. Opracowany specjalnie do spawania wie wiatrowych. Odpowiedni do pracy pr_dem staym lub przemiennym z systemem jedno- lub wieloelektrodowym, do spoin jedno- i wielowarstwowych, przy nieograniczonej gruboúci _czonych elementw.

Specifiche	
Classificazioni	EN ISO 14174 : S A AB 1 57 AC H5
Omologazioni	CE : EN 13479 DB : 51.039.12 UKCA : EN 13479

Le approvazioni si basano sulla posizione della fabbrica. Si prega di contattare ESAB per ulteriori informazioni.

Idrogeno diffusibile	max 5 ml/100g weld metal (Redried flux)
Tipo di scoria	Aluminate-basic
Trasferimento lega	No Silicon and moderately Manganese alloying
Densit	nom: 1.2 kg/dm3
Indice di basicit	nom: 1.9

Consumo di Flusso		
Volt	**kg flusso/ kg filo DC+**	**kg flusso/ kg filo AC**
34 V	1.3 kg	1.2 kg
30 V	1.0 kg	0.9 kg
26 V	0.7 kg	0.6 kg
38 V	1.6 kg	1.4 kg

Stato : Dimension Ø 4.0 mm , Amp 580 A , Velocit di avanzamento 55 cm/min

Classificazioni				
filo	**SFA/AWS - EN ISO**	**EN-come saldato**	**AWS-come saldato**	**AWS-Trattamento termico post saldatura**
Spoolarc 29S	A5.17:EM13K	-	-	-
OK Autrod 12.20	A5.17:EM12/ 14171-A:S2	14171-A: S 38 5 AB S2	A5.17: F7A8-EM12	A5.17: F6P8-EM12
OK Autrod 12.22	A5.17:EM12K/ 14171-A: S2Si	14171-A: S 42 5 AB S2Si	A5.17: F7A8-EM12K	A5.17: F6P8-EM12K
OK Autrod 12.24	A5.23:EA2/ 14171-A:S2Mo; 24598-A:S S Mo	14171-A: S 46 3 AB S2Mo	A5.23: F8A5-EA2-A3	A5.23: F8P5-EA2-A3
OK Autrod 13.24	A5.23:ENi6/ 14171-A: S3Ni1Mo0,2	-	-	-
OK Autrod 13.27	A5.23:ENi2/ 14171-A:S2Ni2	14171-A: S 46 6 AB S2Ni2	A5.23: F8A8-ENi2-Ni2	A5.23: F7P8-ENi2-Ni2
OK Autrod 13.62	A5.23:EG/ 14171-A:SZ3TiB	-	-	-
OK Autrod 13.64	A5.23:EA2TiB/ 14171-A: S2MoTiB	-	A5.23: F8TA8-EA2TiB	-

Approvazioni						
filo	**CWB**	**CE**	**DB**	**VdTÜV**	**ABS**	**DNV**
Spoolarc 81	•	-	-	-	-	-
OK Autrod 12.20	-	•	•	•	-	-
OK Autrod 12.22	-	•	•	•	•	•
OK Autrod 12.24	-	•	•	•	-	-
OK Autrod 13.27	-	•	-	-	-	-

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analisi tipica del deposito									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Al**
Spoolarc 29S As Welded									
0.06	1.96	0.56	0.012	0.017	0.05	0.08	0.03	0.005	0.016
Spoolarc 29S Stress Relieved 1 hr. @ 1150°F									
0.06	1.96	0.56	0.012	0.017	0.05	0.08	0.03	0.005	0.016
Spoolarc 75 As Welded									
0.07	1.84	0.55	0.005	0.016	0.84	0.04	0.01	0.008	-
Spoolarc ENi4 As Welded									
0.08	1.47	0.34	0.006	0.013	1.62	0.05	0.15	-	-
OK Autrod 12.20 AC, 580A, 29V									
0.06	1.4	0.2	-	-	-	-	-	-	-
OK Autrod 12.20 DC+, 580A, 29V									
0.05	1.5	0.2	-	-	-	-	-	-	-
OK Autrod 12.22 AC, 580A, 29V									
0.08	1.4	0.3	-	-	-	-	-	-	-
OK Autrod 12.22 DC+, 580A, 29V									
0.05	1.5	0.3	-	-	-	-	-	-	-
OK Autrod 12.24 AC, 580A, 29V									
0.06	1.5	0.2	-	-	-	-	0.5	-	-
OK Autrod 12.24 DC+, 580A, 29V									
0.05	1.6	0.2	-	-	-	-	0.5	-	-
OK Autrod 13.27 AC, 580A, 29V									
0.07	1.4	0.30	-	-	2.2	-	-	-	-
OK Autrod 13.27 DC+, 520A, 29V									
0.05	1.4	0.30	-	-	2.2	-	-	-	-

analisi tipica del deposito			
Cu	**Nb**	**Ti**	**Co**
Spoolarc 29S As Welded			
0.122	0.002	0.004	0.009
Spoolarc 29S Stress Relieved 1 hr. @ 1150°F			
0.122	0.002	0.004	0.009
Spoolarc 75 As Welded			
0.080	-	0.002	-
Spoolarc ENi4 As Welded			
0.060	-	-	-

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**Ti**
Spoolarc 29S									
0.08	1.15	0.5	0.006	0.013	-	-	-	0.06	-
Spoolarc 71									
0.10	1.22	0.55	0.01	0.01	-	-	-	-	0.07
Spoolarc 75									
0.08	0.89	0.46	0.01	0.00	0.98	0.04	0.01	0.07	-
Spoolarc 81									
0.09	0.95	0.26	0.01	0.01	-	-	-	-	-

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Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**Ti**
Spoolarc ENi4									
0.17	0.73	0.19	0.00	0.00	1.74	-	0.17	0.06	-
OK Autrod 12.20									
0.10	1.06	0.07	-	-	-	-	-	-	-
OK Autrod 12.22									
0.09	1.01	0.19	-	-	-	-	-	-	-
OK Autrod 12.24									
0.09	1.08	0.14	-	-	-	-	0.48	-	-
OK Autrod 13.24									
0.12	1.52	0.23	-	-	0.88	-	0.19	-	-
OK Autrod 13.27									
0.10	1.02	0.14	-	-	2.19	-	-	-	-
OK Autrod 13.62									
0.07	1.55	0.28	-	-	-	-	0.01	-	0.14
OK Autrod 13.64									
0.07	1.22	0.28	-	-	-	-	0.49	-	0.14

Typical Wire Composition %
B
OK Autrod 13.62
0.013
OK Autrod 13.64
0.013

Propriet meccaniche tipiche					
filo	**Stato**	**Resistenza allo snervamento**	**Resistenza alla trazione**	**Allungamento**	**Intaglio a V Charpy**
Spoolarc 29S	Come saldato	532 MPa	622 MPa	25 %	57 J @ -40 °C 43 J @ -46 °C 41 J @ -51 °C
Spoolarc 75	Come saldato	556 MPa	646 MPa	28 %	91 J @ -40 °C 83 J @ -51 °C
Spoolarc 81	Come saldato	415 MPa	500 MPa	30 %	119 J @ -29 °C 100 J @ -40 °C 71 J @ -51 °C 50 J @ -62 °C
Spoolarc ENi4	Come saldato	607 MPa	677 MPa	27 %	141 J @ -40 °C 107 J @ -51 °C 88 J @ -62 °C
OK Autrod 12.20	Come saldato AWS DC+	415 MPa	500 MPa	30 %	125 J @ -30 °C 100 J @ -40 °C 70 J @ -50 °C 50 J @ -62 °C
OK Autrod 12.20	Come saldato EN AC	420 MPa	500 MPa	33 %	140 J @ -30 °C 130 J @ -40 °C 80 J @ -50 °C
OK Autrod 12.22	Come saldato AWS DC+	440 MPa	530 MPa	31 %	120 J @ -30 °C 100 J @ -40 °C 70 J @ -50 °C 50 J @ -62 °C

OK Flux 10.72

Propriet meccaniche tipiche					
filo	**Stato**	**Resistenza allo snervamento**	**Resistenza alla trazione**	**Allungamento**	**Intaglio a V Charpy**
OK Autrod 12.22	Come saldato EN AC	425 MPa	560 MPa	27 %	140 J @ -30 °C 130 J @ -40 °C 80 J @ -50 °C
OK Autrod 12.24	Come saldato AWS DC+	500 MPa	590 MPa	25 %	60 J @ -30 °C 40 J @ -40 °C 35 J @ -46 °C
OK Autrod 12.24	Come saldato EN AC	535 MPa	600 MPa	24 %	70 J @ -30 °C 50 J @ -40 °C 40 J @ -50 °C
OK Autrod 13.24	Come saldato AWS DC+	530 MPa	660 MPa	28 %	90 J @ 0 °C 35 J @ -40 °C
OK Autrod 13.27	Come saldato EN AC	520 MPa	610 MPa	27 %	120 J @ -30 °C 100 J @ -40 °C 80 J @ -50 °C 60 J @ -60 °C
OK Autrod 13.27	Come saldato AWS DC+	490 MPa	610 MPa	30 %	100 J @ -40 °C 80 J @ -51 °C 50 J @ -62 °C
OK Autrod 13.62	Come saldato (acc. AWS) Plate thickness: 12mm; Heat Input: 2.2 kJ/mm; Side 1: 600A, 32V, 53cm/min; Side 2: 700A, 32V, 60cm /min; DC+	500 MPa	610 MPa	27 %	50 J @ -62 °C
OK Autrod 13.64	Come saldato (acc. to AWS) Plate thickness 12mm Heat input 2.2kJ /mm 700A, 32V, 60cm /min DC+	560 MPa	660 MPa	27 %	50 J @ -62 °C