Нелегированная порошковая проволока для дуговой сварки ELCOR R 71/72/SC/CM

Технические характеристики

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Rutile Type Flux Cored Wire

ELCOR R 71

Standards

TS EN ISO 17632-A	: T 42 4 P C 1 H5
EN ISO 17632-A	: T 42 4 P C 1 H5
AWS A5.20	: E 71T-1C-J

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	P	S
0.06	0.5	1.3	0.015	0.015

Mechanical Properties

Heat Treatment	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-40°C)	Elongation (($L_o=5d_o$) (%)
AW	min. 420	500- 640	min. 50 J	min. 22

AW: as welded

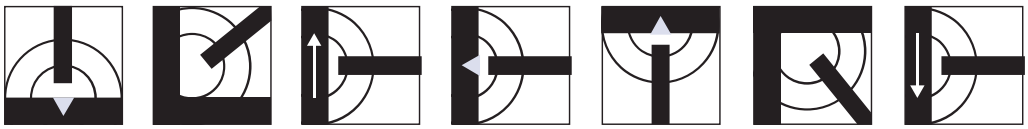
Typical Base Material Grades

- S235JR, S275JR, S235J2G3-S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L360NB, L290MB L360MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, S255NL-S355NL,GE200-GE260

Features and Applications

- Rutile type flux-cored wire which is used for the production welding of machine and welding applications on ship, industry vehicle building and steel constructions in all positions
- Provides high mechanical properties, proper, smooth, X-ray safety seams
- It is economical as it has high melting ability and can work under high current in all positions
- Shielding gas: %100 CO_2

Welding Positions



Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500008	1.20	0.047”	4.5	D 200
3010500018	1.20	0.047”	15	D 300
3010500023	1.20	0.047”	15	BS 300
3010500020	1.60	0.062”	15	BS 300
3010500035	1.60	0.047”	200	BIG PACK

Approvals: ELCOR R71 (CO2): TL, DNV-GL, BV, ABS, LR, RS, DB NK, RINA, CE, TÜV, SEPRO, CWB

Standards

TS EN ISO 17632-A	: T 46 2 P M 1
EN ISO 17632-A	: T 46 2 P M 1
AWS A5.20	: E71 T-1M

Chemical Composition of Weld Metal (Typical)

C	Si	Mn
0.06	0.5	1.3

Mechanical Properties

Heat Treatment	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-20°C)	Elongation ((L_o=5d_o) (%)
AW	min. 460	530- 600	min. 50 J	min. 22

AW: as welded

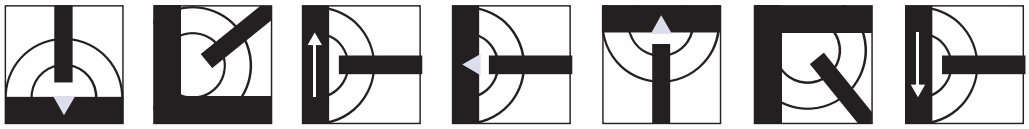
Typical Base Material Grades

- S235JR, S275JR, S235J2G3- S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L360NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, S255NL-S355NL, GE200-GE260

Features and Applications

- Rutile type flux cored wire which is used for the production welding of machine and welding applications on ship, and steel constructions in all positions. Provides high mechanical proper ties, proper, smooth, X-ray safety seams
- It is economical as it has high melting ability and can work with high current in all positions. Shielding Gas: M21 (CO_2)

Welding Positions



Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500112	1.20	0.047”	15	BS 300

Approvals: CE, SEPRO

Rutile Type Flux Cored Wire

ELCOR R 72

Standards

TS EN ISO 17632-A	: T 46 4 P C 1 H5
EN ISO 17632-A	: T 46 4 P C 1 H5
AWS A5.20	: E 71T-1C/-9C J

Chemical Composition of Weld Metal (Typical)

C	Si	Mn
0.06	0.5	1.3

Mechanical Properties

Heat Treatment	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-40°C)	Elongation ($L_o=5d_o$) (%)
AW	min. 460	530 - 670	min. 47 J	min. 22

AW: as welded

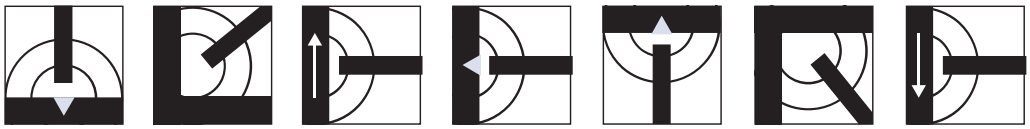
Typical Base Material Grades

- S235JR, S275JR, S235J2G3-S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L415NB, L290MB L415MB , P235G1TH, P255G1TH, P235GH-P355GH , P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, S255NL-S355NL, GE200-GE260

Features and Applications

- Rutile type flux-cored wire which is used for the production welding of machine and welding applications on ship, industry vehicle building and steel constructions in all positions
- Provides high mechanical properties, proper, smooth, X-ray safety seams
- It is economical as it has high melting ability and can work under high current in all positions
- Shielding gas: %100 CO_2

Welding Positions



Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter (mm)	Weight (Kg)	Package Type
3010500409	1.2	15	D 320

Seamless Rutile Type Flux Cored Wire

ELCOR R 71 SC

Standards

TS EN ISO 17632-A	: T 46 4 P C1 H5 / T46 3 P M1 H5
EN ISO 17632-A	: T 46 4 P C1 H5 / T46 3 P M1 H5
AWS A5.20	: E71 T-1C/-1M H4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn
0.05	0.5	1.3

Mechanical Properties

Heat Treatment	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-30°C) (with M21 gas)	Impact Strength (ISO-V/-40°C) (with CO_2 gas)	Elongation ($(L_o=5d_o)$ (%)
AW	min. 460	530-680	min. 47 J	min. 47 J	min. 22

AW: as welded

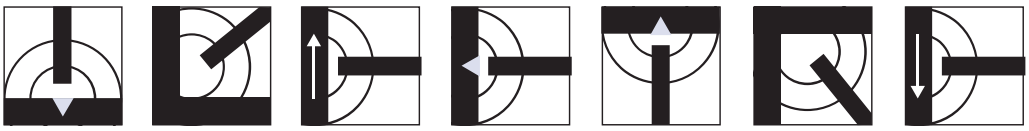
Typical Base Material Grades

- S235JR, S275JR, S235J2G3-S355J2G3, P 235T1-P355T1 , P235T2-P355T2, L210NB-L360NB, L290MB L415MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, S255NL-S355NL, GE200-GE260

Features and Applications

- Rutile type flux cored wire which is used for the production welding of machine and welding applications on ship, and steel constructions in all positions. Provides high mechanical properties, proper, smooth, X-ray safety seams. It is economical as it has high melting ability and can work with high current in all positions. Shielding Gas: CO_2 or M21

Welding Positions



Current Type

FCAW / D.C. (+)

Operating Data

Diameter (mm)	Diameter (inch)	Weight (Kg)	Package Type
1.20	0.047”	15	D 300

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