



TECHNICAL DESCRIPTION

FT-DT.72.00

EUROTROD LC 72

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CERTIFIED COMPANY:



CLASSIFICATION:

**AWS A5.4: E 2209-15
EN ISO 3581-A E 22 9 3 N L B 42**

DESCRIPTION:

Basic coated electrode for welding stainless ferritic-austenitic Cr/Ni/Mo Steels (Duplex steels). Highly resistant to pitting corrosion and chloride induced stress corrosion craking (CSCC). Service temperature up to 250 °C

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

C	Si	Mn	Cr	Ni	Mo	N
0,035	0,70	1,6	23	9	3,1	0,16

Mechanical Properties:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)	CHARPY V (J)	
			+20°C	-50°C
>600	>750	>25	>65J	>47J

PRODUCT INFORMATION:

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type	Pieces /Packet (Un)	Weight /Packet (kg)
2,5	300	50 – 75	DC (+)	110	2,0
3,2	350	75 – 110	DC (+)	68	2,5
4,0	350	110 – 145	DC (+)	49	2,5

WELDING POSITIONS:

