

Coreweld 89

A metal cored wire for high strength applications (>890 MPa) developed for use with argon / carbon dioxide shielding gas. Optimal mechanical and welding results are achieved with Ar/8%CO₂ gas mixture. Excellent -40 degrees C toughness is achieved along with low diffusible hydrogen. The application area is anywhere where high strength steels are to be joined for example cranes, forestry machinery, load support and handling equipment.

| Dane techniczne | |
|-----------------|--|
| Klasyfikacje | SFA/AWS A5.28 : E120C-G H4 EN ISO 18276-A : T 89 4 Z M M21 3 H5 |
| Aprobaty | CE : EN 13479 UKCA : EN 13479 |

Zatwierdzenia s oparte na lokalizacji fabryki. Aby uzyska wiecej informacji, skontaktuj si z ESAB.

| | |
|------------------|----------------------------------|
| Prd spawania | DC+ |
| Wodór dyfundujcy | < 4 ml/100g |
| Rodzaj stopu | C Mn, low alloy steel (Ni-Cr-Mo) |
| Gaz osonowy | M20, M21 (EN ISO 14175) |

| Typowe waciwoci mechaniczne | | | |
|-----------------------------|----------------------|---------------------------|------------------|
| Warunki | Granica plastycznoci | Wytrzymaao na rozciąganie | Wyduenie wzgldne |
| M21 shielding gas | | | |
| Po spawaniu | 910 MPa | 965 MPa | 17 % |
| M20 shielding gas | | | |
| Po spawaniu | 931 MPa | 993 MPa | 17 % |

| Udarno Charpy V | | |
|--------------------------|-------------------|-----------|
| Warunki | Temperatura testu | Udarno KV |
| M21 shielding gas | | |
| Po spawaniu | -40 °C | 95 J |
| M20 shielding gas | | |
| Po spawaniu | -40 °C | 82 J |

| Typowy skad chemiczny stopiwa % | | | | | | | | | |
|---------------------------------|------|------|-------|-------|------|------|------|------|------|
| C | Mn | Si | S | P | Ni | Cr | Mo | V | Cu |
| M20 shielding gas | | | | | | | | | |
| 0.105 | 1.32 | 0.53 | 0.010 | 0.008 | 2.49 | 0.58 | 0.71 | 0.01 | 0.01 |

| Typowy skad chemiczny stopiwa % | |
|---------------------------------|--|
| Nb | |
| M20 shielding gas | |
| 0.01 | |

| Dane wydajności stopiwa | | | | |
|-------------------------|-----------|---------|-----------------------|-----------------|
| rednica | A | V | Prdko podawania drutu | Wydajno stopiwa |
| 1.2 mm | 100-360 A | 16-32 V | 1.8-13.0 m/min | 1.3-8.0 kg/h |