

TIGWELD 2

TIG Rods [GTAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 636-A : W 42 5 W3Si1 DIN 8559 : W SG2 AWS A-5.18 : ER 70 S-6	UDT	Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Shipbuilding&Offshore Agriculture Light construction and hobby

- Solid rod for TIG welding of unalloyed and low alloyed steels.
- The weld metal is characterized by high metallurgical purity.
- Very low concentration of S and P.
- High wettability, comfort welding process for a welder, even not much experienced.
- The limited amount of silicates on the top layer eliminates the inter-pass cleaning process, which speeds up the welding process.

Application

All types of structures and elements made of materials that can be joined with this type of weld metal.

Pressure devices and elements, structures made of fine-grain steel, carbon-manganese steel, welded joints in ship and boiler steels.

Base material

	EN
Construction steels:	S235-S355
Boiler plates:	P235GH-P355GH
Pipelines:	L235-L355N
Finegrained steels:	S275-S420

Typical chemical composition %

C	Si	Mn
0,09	0,85	1,45

Typical mechanical properties

Yield strength Re [N/mm²]	>420
Tensile strength Rm [N/mm²]	500-640
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (-50°C) /
Shielding gases acc. to EN ISO 14175	Il - Ar /

Welding parameters and packing

Ø	Length [mm]	Weight of packet [kg]
1,6	1000 /	5,0 / 25,0
2,0	1000 /	5,0 / 25,0
2,4	1000 /	5,0 / 25,0
3,0	1000 /	5,0 / 25,0

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