

## TIGWELD 1 (N)

TIG Rods [GTAW]

Low alloyed steel

CLASSIFICATION:	APPROVALS:		APPLICATION:		
EN ISO 636-A : W 42 4 2Si1 AWS A-5.18 : ER 70S-3			Power generation industry Constructions & Engineering		
			Petrochemical and chemical industry		
<ul> <li>Solid rod for TIG welding of unalloyed and low-alloy steels with reduced Si% and Mn% content</li> <li>Meet the typical requirements for nuclear power plant applications</li> <li>The weld metal is characterized by high metallurgical purity, very low S and P concentration</li> <li>The limited amount of silicates on the face surface eliminates the interpass cleaning process, which speeds up the joint</li> </ul>					
Application					
Pressure devices and installations, structures made of fine-grained, carbon and boiler steels					
Base material					
		EN			
Low alloyed and unalloyed steels		S235-S355			
Boiler steels		P235GH-P355GH			
Pipes		L235-L355N			
Fine grained steels		S275-S420			
Typical chemical composition %					
CSiMnC0,080,601,20<	<b>u Co</b> 0,25 <0,025	<b>P S</b> <0,01 <0,0	2		
Typical mechanical properties					
Yield strength Re [N/mm2]	>420				
Tensile strength Rm [N/mm2]	500-640				
Elongation A5 [%]	>20				
Impact energy Kv [J]	>47 J (-40°C) /				
Welding current	= -	]			
Welding positions					
Additional description	The product is sub certification proce order and delivery Metalweld-Fiprom	bject to a special c edure. Before placi y should be confirr Polska, Sosnowie	order, production, delivery and ng an order, the detailed terms of ned in the Sales Department of c.		
Additional description Shielding gases acc. to EN ISO 14175	The product is sub certification proce order and delivery Metalweld-Fiprom	bject to a special c edure. Before plac y should be confirr Polska, Sosnowie	order, production, delivery and ng an order, the detailed terms of ned in the Sales Department of c.		

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

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