TIGWELD 3

TIG Rods [GTAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 636-A : W 46 4 W4Si1 DIN 8559 : W SG3 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 unalloyed and low alloyed steels.
- The weld deposit is characterized by very high chemical purity, resulting in excellent weldability.
- The liquid weld deposit shows a very good combination of high wettability with the limitation of excessive fluidity.
- Reducing the occurrence of silicates and other impurities further facilitates the welding process.
- The material is particularly easy to use, even for not experienced welders.

Application

A material with a very versatile use. Increased strength properties extend the use of the weld metal to materials with a yield point of up to 460 [MPa] in such applications as shipbuilding, pressure structures, load-bearing structures, etc.

Base material

	EN
Construction steels:	S235-S355
Boiler plates:	P235GH-P355GH
Pipelines:	P235-P355N
Finegrained steels:	S275-S420, S460

Typical chemical composition %

C	Si	Mn
0,07	0,85	1,63

Typical mechanical properties

Yield strength Re [N/mm2]	>460
Tensile strength Rm [N/mm2]	530-680
Elongation A5 [%]	>22
Impact energy Kv [J]	>47J (-40°C) /
Shielding gases acc. to EN ISO 14175	I1 - 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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