

## TIGWELD 1 (N)

TIG Rods [GTAW]

Low alloyed steel

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>				
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 style="list-style-type: none"><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 %						
C	Si	Mn	Cu	Co	P	S
0,08	0,60	1,20	<0,25	<0,025	<0,01	<0,02
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 subject to a special order, production, delivery and certification procedure. Before placing an order, the detailed terms of order and delivery should be confirmed in the Sales Department of Metalweld-Fiprom Polska, Sosnowiec.					
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
2,0	1000 /	5,0
2,4	1000 /	5,0
3,0	1000 /	5,0

# **METALWELD-FIPROM POLSKA spółka z o.o.**

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl