

## 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

<b>Yield strength Re [N/mm<sup>2</sup>]</b>	>420
<b>Tensile strength Rm [N/mm<sup>2</sup>]</b>	500-640
<b>Elongation A5 [%]</b>	>20
<b>Impact energy Kv [J]</b>	>47J (-50°C) /
<b>Shielding gases acc. to EN ISO 14175</b>	l1 - Ar /

### Welding parameters and packing

∅	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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