



TIG 15CDV6

Classification

AIR 9117 : 15 CDV 6

EN 4334 : 15 CrMnMoV5-4-9-3

Description & Applications

Not copper coated solid rod for GTAW of steels such as 15CrMoV6, 25CrMo4, 35CrMo4, 40CrMoV12. Product of high purity for welding without micro-porosity. Could also be used for build up of tool steels.

Main applications: Hardfacing of fan, tools steels...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	V	P	S	P+S
Min	0.12		0.80	1.25	0.80	0.20			
Max	0.15	0.20	1.10	1.50	1.00	0.30	0.020	0.020	0.040
Type	0.14	0.15	1.0	1.4	0.9	0.25	0.015	0.015	<0.040

All Weld Metal Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	Hardness
Min				
Max	-	-	-	-
Type	930	1080-1280	10	42 HRC as welded

* Depending on heat treatment

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175: I1 (Ar): 6-12 l/min Back shielding : I1 (Ar) / N1 (Nitrogen) : 3-6 l/min

FT En-TE10-210210

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