TIG 17/4MO

Old reference: TIG 17-4Mo

Classification

ISO 14343-A : W Z 17 4 Mo
EN4689 : X4CrNiMo16-5-1
AIR 9117 : Z8CND17-04

Description & Applications

Solid rod for GTAW of stainless steels with similar chemical composition like X2CrNiMo13-4, APX4S*.

* Trademark of Aubert & Duval

Main applications: Repairing of Pelton turbine.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S	N
Min				15.00	4.00	0.80	-			0.02
Max	0.06	0.70	1.50	17.00	5.00	1.50	-	0.025	0.005	0.08
Type	0.05	0.30	0.90	16.0	4.4	1.0	0.10	0.02	0.003	0.03

All Weld Metal Mechanical Properties*

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	-	-	-	-	-
Max	-	-	-	-	-
Type	750	900	16	20°C	60

* After PWHT at 620°C/4h

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

Preheating of work-pieces at 100-150°C. Maintain temperature during welding and then, slow cooling at still air. Anneahling is advised at 580-620°C/4-8h.

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