



TIG 19/13S

Classification

ISO 14343-A : W Z 19 13 Si N L

Description & Applications

Low carbon solid rod for GTAW of stainless steels with similar chemical composition like alloy X1CrNiSi 18-15-4 (UR® S1). High corrosion resistance in nitric acid environment.

Main applications: Storage of nitric acid.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	P	S	Co	Ti	B	N
Min												
Max												
Type	0.010	4.0	1.7	18.2	12.7	0.03	0.015	0.005	0.030	0.005	0.001	0.075

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	-	-	-	-
Max	-	-	-	-
Type	270	585	40	-

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

Back shielding with Argon or Nitrogen gas or with copper backing support to avoid "back end" rust phenomena.

FT En-TN42-200406