



## TIG 22/21CO

Old reference: TIG N155

### Classification

ISO 14343-A : W Z 22 21 3 CoWNbN

AMS : 5794

### Description & Applications

Solid rod for GTAW of similar chemical composition alloys. Good resistance to heat and corrosion.

**Main applications:** Aeronautical industry.

### Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	W	Cb	P	S	Co	N	Ta
Min			1.00	20.00	19.00	2.50	2.00	0.75			18.50	0.10	
Max	0.10	1.00	2.00	22.50	21.00	3.50	3.00	1.25	0.04	0.03	21.00	0.20	0.05
Type	0.08	0.40	1.40	22.0	20.5	3.2	2.8	1.0	0.01	0.005	20.0	0.15	0.015

### All Weld Metal Mechanical Properties\*

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	-	-	-	-
Max	-	-	-	-
Type	320	410	40	-

\* After PWHT at 1200°C/1h/Air

### 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-TN41-200406