



TIG F60

Old reference: TIG 80SD2

Classification

AWS A5.28 : ER80S-D2

ISO 636-B : W4M31

Description & Applications

Copper coated solid rod for GTAW of creep resisting steels alloyed with Molybden (0.5% Mo) used at temperatures up to 500°C.

Main applications: Piping systems, boilers...

Base materials:

Steels and pipes for boiler and pressure vessels:

NF A 36-206	DIN 17155-17245	DIN 17175-17102	BS	ASTM
15D3	HI	19Mn5	BS 1504 Gr 245	A335 Gr P1
18MD4-05	HIII	15Mo3	BS 3100 Gr B1	A352 GrLC1
	GS C 25 17 Mn4	GS22Mo4 St35.8	BS 3606 Gr 243, 245	A204 Gr. A et B
		St 45.8		A155 Gr CM 65/70
		17Mn4		
		StE255		
		StE420		

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti+Zr	V	P	S
Min	0.07	0.50	1.60			0.40						
Max	0.12	0.80	2.10	-	0.15	0.60	0.50	-	-	-	0.025	0.025
Type	0.08	0.70	1.9	0.10	0.07	0.50	0.20	0.01	0.005	0.01	0.01	0.01

All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	470	550	17	-30°C
Max				27
Type	550	630	25	-50°C
				50

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-TF01-190219

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