



# TIG F66S

## Classification

AIR 9117 : 25 CD 4

EN 4331 : 25CrMnMo4-2-2

## Description & Applications

Not copper coated solid rod for GTAW of steels such as 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 fans, tools steels...

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Mo	Ni	P	S	P+S
Min	0.21		0.40	0.80	0.17				
Max	0.25	0.25	0.80	1.20	0.30	0.30	0.020	0.020	0.040
Type	0.23	0.2	0.7	1.2	0.2	0.15	0.015	0.015	<0.040

## All Weld Metal Mechanical Properties

	R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	Hardness
Min				
Max	-	-	-	-
Type	750	880-1080	12	46 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-TE02-190219

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