



TIG F75

Old reference: TIG Corten

Classification

AWS A5.28 : ER80S-G

ISO 16834-A : W Z Mn3Ni1Cu

Description & Applications

Solid copper coated rod, low alloyed with Nickel, Chromium and Copper for GTAW of astmospheric corrosion resistant steels.

Main applications: Public equipment and constructions, shipbuilding...

Base materials:

Astmospheric corrosion resistant steels:

UNS	DIN	EN	Mat. N°
K 12032	WT St37-2	S255 JOW	1.8958
K 11541	WT St37-3	S235 J2W	1.8961
K 11538	WT St52-3	S355 J2G1W	1.8963
Trademarks: COR-TEN A,B,C – PATINAX – INDATEN – ACOR			

Typical Weld Metal Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S
Min									
Max					Not specified				
Type	0.06	0.80	1.4	0.29	0.75	0.05	0.40	0.01	0.01

All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	-	550	-	-
Max				
Type	540	640	24	-40°C 65

Weld 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

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