



# TIG F57N

## Classification

ISO 636-A : W Z 2Si(Cr)

## Description & Applications

Copper coated TIG rod to weld low alloyed standard construction / boiler steels like S235-S355, P235-P355 and S255N-S355N. This chromium content higher than ER70S-3 or ER70S-6 gives a particular resistance to corrosion/erosion due to the water.

**Main applications:** For pipping (in particular Nuclear) for root pass for high quality level of welding with specific control.

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu	Ti	Zr	V	P	S
Min												
Max						Not specified						
Type	0.09	0.60	1.1	0.32	0.09	0.02	0.16	0.002	0.002	0.001	0.012	0.012

## All Weld Metal Mechanical Properties

	R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )	
Min	400	480	22	-	-
Max				-	-
Type	530	610	25	-20°C	100
				-30°C	80

## 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-TA11-260415

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