

TG 150

TIG Welding Wire - High Strength and Low Alloyed Steels

Standards	
AWS/ASME SFA - 5.28	ER80S-Ni1
EN ISO 636 - A	W 46 6 3Ni1
TS EN ISO 636 - A	W 46 6 3Ni1

Properties and Applications

Low alloyed GTA (TIG) welding rod for steels subjected to operating temperatures down to -60°C. Weld metal has high strength and high toughness. Suitable to use in petrochemical, chemical, oil/gas industries and off-shore platforms, especially used for root and fill passes of pipes, boilers, tanks and also valves, pumps which are made of cast or forged steels.

Materials			
Width	DIN	ASTM	API
11MnNi5-3			
13MnNi6-3			
S275NL - S460NL	TSIE 285 - TSIE 460		
S275ML - S460ML			
P275NL2 - P460NL2	ESIE 285 - ESIE 460		
P355ML2 - P460ML2			
		A333 - A334 (Gr 1-6)	
		A350 (Gr LF2-LF6)	
		A352 (Gr LCB-LCC)	
L450MB			X65

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Ni
Welding Wire	0.10	0.60	1.10	0.90

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	I1	480	570	28	-60°C → 90

* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions

PA PB PC PD PE PF

Polarity:

Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
2.00x1000
2.40x1000
3.20x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
22110HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
22110IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube
22110LBKM2	3.20x1000	5 kg	5.30	4	21.40	Cardboard Tube

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.