

TG 171

TIG Welding Wire - High Strength and Low Alloyed Steels

Standards

AWS/ASME SFA - 5.28	ER80S-Ni2
EN ISO 636 - A	W 42 9 2Ni2
TS EN ISO 636 - A	W 42 9 2Ni2

Properties and Applications

Low alloyed GTA (TIG) welding rod for steels subjected to operating temperatures down to -90°C. Produces high strength and tough welded joints. Suitable to use in petrochemical, chemical, oil/gas industries and offshore platforms, especially root and fill passes of pipes, boilers, tanks and also valves, pumps which are made of cast or forged steels.

Materials

Width	DIN	ASTM
11MnNi5-3		
13MnNi6-3		
S275NL- S460NL	TStE 285 - TStE 460	
S275ML - S460ML		
P275NL2 - P460NL2	ESTe 285 - ESTe 460	
P355ML2 - P460ML2		
		A203 (Gr A-B)
		A333 - A334 (Gr 1-7)
		A350 (Gr LF2-LF5-LF6)
		A352 (Gr LC1-LC2)

Typical Chemical Features of the Welding Wire







Type of Analysis	C	Si	Mn	Ni
Welding Wire	0.09	0.55	1.10	2.45

Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	470	550	20	20°C → 200	-90°C → 47
Isıl İşlem Sonrası (620°C 1 Saat)	500	630	26	-90°C → 150	

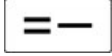
Application Information

Welding Positions

PA PB PC PD PE PF

Polarity:



Protection Gas:
I1

Welding Parameters & Efficiency

Diameter x Length (mm)
2.40x1000

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
22113IBKM2	2.40x1000	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.