



CEWELD SG TITAN Tig

TYPE	Special TIG rod with de-oxidation additions for improved welding properties																											
APPLICATIONS	recommended for applications that require high purity of the weld metal. Ideal for diluted, rusty, painted or galvanized steel plates in maintenance and repair. Car restoration, body shops, frames and overhaul work																											
PROPRIÉTÉS	excellent desoxidation properties due to the addition of Zr, Ti and Aluminium.																											
CLASSIFICATION	AWS EN ISO		A 5.18: ER 70S-2 636-A: W 46 2 2Ti																									
CONVIENT POUR	Rp< 460 MPa (70ksi) ISO 15608: 1.1 $ReH \leq 275 \text{ MPa}$, 1.2 $275 < ReH \leq 360 \text{ MPa}$, 1.3 $ReH > 360 \text{ MPa}$, 2.1 360 < ReH ≤ 460 MPa 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425,1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL A, B, D ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X60 5																											
AGRÉMENTS	CE																											
POSITIONS DE SOUDAGE	 PA  PB  PC  PD  PE  PF  PG																											
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu	Al	Ti+Zr																
	0.05	0.5	1.2	0.01	0.01	0.034	0.018	0.006	0.002	0.11	0.1	0.17																
PROPRIÉTÉS MÉCANIQUES	<table><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">Rp0,2 (MPa)</th><th rowspan="2">Rm (MPa)</th><th rowspan="2">A5 (%)</th><th colspan="2">Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>RT</th><th>-30°C</th></tr><tr><td>As Welded</td><td>470</td><td>560</td><td>24</td><td>100</td><td>55</td><td>HRc</td></tr></table>												Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness	RT	-30°C	As Welded	470	560	24	100	55	HRc
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ETUVAGE	Not required																											
GAS ACC. EN ISO 14175	I1																											



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SG TITAN TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405531
SG TITAN TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405548
SG TITAN TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405562
SG TITAN TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663405579