



# CEWELD SG TITAN Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |     |                                       |                      |                    |                         |       |       |       |          |     |       |
|---------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|---------------------------------------|----------------------|--------------------|-------------------------|-------|-------|-------|----------|-----|-------|
| TYPE                                              | Speciale TIG staaf met des-oxidatie elementen voor verbeterde laseigenschappen                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |     |                                       |                      |                    |                         |       |       |       |          |     |       |
| TOEPASSINGEN                                      | Aanbevolen voor toepassingen die een hoge zuiverheid van het lasmetaal vereisen. Ideaal voor vervuilde, roestige, geverfde of gegalvaniseerde staalplaten bij onderhoud en reparatie. Autoreparatie, carrosseriebedrijven, frames en revisiewerkzaamheden.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |     |                                       |                      |                    |                         |       |       |       |          |     |       |
| EIGENSCHAPPEN                                     | Ultstekende des-oxidatie eigenschappen vanwege de toevoeging van Zr, Ti en Al.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |     |                                       |                      |                    |                         |       |       |       |          |     |       |
| CLASSIFICATIE                                     | AWS<br>EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |     | A 5.18: ER 70S-2<br>636-A: W 46 2 2Ti |                      |                    |                         |       |       |       |          |     |       |
| GESCHIKT VOOR                                     | <b>Rp&lt; 460 MPa (70ksi) ISO 15608: 1.1</b> $\text{ReH} \leq 275 \text{ MPa}$ , <b>1.2</b> $275 < \text{ReH} \leq 360 \text{ MPa}$ , <b>1.3</b> $\text{ReH} > 360 \text{ MPa}$ ,<br><b>2.1</b> $360 < \text{ReH} \leq 460 \text{ MPa}$<br>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<br>S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL<br>A, B, D<br>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 |     |                                       |                      |                    |                         |       |       |       |          |     |       |
| GOEDKEURINGEN                                     | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |     |                                       |                      |                    |                         |       |       |       |          |     |       |
| LASPOSITIES                                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                   |     |                                       |                      |                    |                         |       |       |       |          |     |       |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | 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  |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |     | R <sub>p0,2</sub> (MPa)               | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       |       |       | Hardness |     |       |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |     | 470                                   | 560                  | 24                 | RT                      |       | -30°C |       | HRc      |     |       |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |     |                                       |                      |                    |                         |       |       |       |          |     |       |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |     |                                       |                      |                    |                         |       |       |       |          |     |       |



# CEWELD SG TITAN Tig

|                           |           |         |               |
|---------------------------|-----------|---------|---------------|
| 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 |