

TIG WELDING RODS



Wire dia. mm	Length mm	Weight kg	Art. no.	PU/Qty.
1.0	1000	5	0982 711 0	1
1.6			0982 711 6	
2.0			0982 712 0	
2.4			0982 712 4	
3.2			0982 713 2	

for stainless steel weldings

SG X2 CrNiMo 1912, DIN 8556

Designation as per AWS A 5.9: ER 316 L-Si

Material number 1.4430

- Suitable for welded joints on the following basic materials:
1.4301, 1.4306, 1.4401, 1.4404, 1.4408, 1.4435, 1.4436, 1.4541, 1.4550, 1.4552, 1.4571, 1.4573, 1.4580, 1.4581, 1.4583

Guide analysis of wire in %

C	Cr	Ni	Mo
0.025	18.5	12.0	2.7

Quality value of pure weld metal

Heat treatments	Argon	Creep limit Rp 0.2 N/mm ²	Strength Rm N/mm ²	Breaking elongation A5 %	Impact energy ISO V (J) Rt %
U	X	> 350	600-700	> 30	> 100

Welding rods are welded with DC pole.

Wire dia. mm	Length mm	Weight kg	Art. no.	PU/Qty.
2.0	1000	5	0982 752 0	1
2.4			0982 752 4	
3.2			0982 753 2	

for aluminium weldings

S-ALMg 5, DIN 1732

Designation as per ASME: ER 5356

Material number 3.3556

- Suitable for welded joints on the following basic materials:
AlMg₂Mn_{0,8}, AlMg_{2,7}Mn, AlMg₃, AlMg_{4,5}Mn, AlMg₅ (max. +80°C), AlMgMn
G-AlMg₃, G-AlMg₃Si, G-AlMg₅, G-AlMg₅Si,
G-AlMg₃ (Cu) – not approved by TÜV

Guide analysis of wire in %

Mg	Mn	Cr	Ti	Al
4.3-5.5	0-0.6	0-0.3	0.2	Remainder

Quality value of pure weld metal

Thermal treatment	Shielding gas	Tensile strength N/mm ²	Creep limit Rp 0.2 N/mm ²	Breaking elongation A5 %
U	Pure argon	220-260	> 90	> 20

Welding rods are welded with AC.