



TIG 17/4MO

Old reference: TIG 17-4Mo

Classification

ISO 14343-A : W Z 17 4 Mo

Description & Applications

Solid rod for TIG welding and repairing steels of similar chemical composition.

Main applications: Repairing of Pelton* turbine.

* Trademark of Aubert & Duval

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	P	S	Fe
0.05	0.3	0.9	16.0	4.4	1.0	<0.03	<0.02	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
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Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

Preheating of work-pieces at 100-150°C. Maintain temperature during welding and then slow cooling at still air. Annealing is advised at 580-620°C/4-8h.

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