



# TIG 22/21CO

Old reference: TIG N155

## Classification

ISO 14343-A : W Z 22 21 3 CoWNbN      AMS : 5794

## Description & Applications

Solid rod for TIG welding of similar alloys. Good resistance to heat and corrosion.

**Main applications:** For turbines and in aeronautical industry.

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Co	W	Nb	N <sub>2</sub>	Fe
0.1	0.4	1.5	22.0	21.0	3.2	20.0	2.8	1.0	0.15	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	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

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