



TIG BMS

Classification

AIR 9117 : 8 CD 12

Description & Applications

Solid rod for TIG welding of steels such as 15CrMoV6, 25CrMo4, 35CrMo4, 20CrMo12... Product of high purity for welding without microporosity.

It is also used for hardfacing of tool steels.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	P	S	Fe
0.06	0.7	1.1	2.7	1.0	<0.015	<0.015	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	Hardness
440	570	24	~36 HRC
After PWHT 730°C/2h			

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding: Nitrogen / H ₂ : 3-6 l/min

Preheating of work-pieces at ~250°C. Post weld heat treatment: 730°C/2h

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