



TIG F61

Old reference: TIG 70SA1

Classification

AWS A5.28 : ER70S-A1

ISO 636-A : W 2Mo

Description & Applications

GTAW rods for welding creep resisting steels (alloyed Mo) used at temperatures up to 500°C. Good resistance to Hydrogen attacks (chemical installations).

Main applications: For piping systems, boilers...

Base materials

Aciers de construction et aciers résistant au fluage / température

EN	ASTM
16Mo3	A161/A209/A250 gr T1 ;A335 gr P1
P355GH	A537 Cl1; A414 gr G ; A612
S420N – S460N	A572 grade 65 , A633 grade E
S500N	A225 grade C , A517 grade...
P460N	A225 grade C
S420NL - S500NL	A633 grade E, A225 grade C , A517 grade
P420NH - P500NH	A633 grade E, A225 grade C , A517 grade

Typical Chemical Composition (%)

C	Si	Mn	Mo	Cu	P	S	Fe
0.09	0.6	1.2	0.5	0.15	0.01	0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
520	630	26	+20°C 200

Welding Current & Instructions

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

Ind.12



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