



TIG SCVS

Classification

AIR 9117 : 15CDV6

Description & Applications

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

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	V	P	S	Fe
0.14	0.15	1.0	1.4	0.9	0.25	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	Hardness
930	1080-1280	10	42 HRC
Depending on heat treatment	Depending on heat treatment		

Welding Current & Instructions

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

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