



# TIG ZR702

## Classification

AWS A5.19 : ERZr2

## Description & Applications

Solid rod for GTAW of pur Zirconium. Weld metal deposit with good strength and ductility.

**Main applications:** Welding of UNS R60702 zirconium alloy

## Typical Chemical Composition ( % )

	Fe+Cr	O	H	N	C	Hf	Zr+Hf
Min		0.11					
Max	0.20	0.15	0.005	0.015	0.03	4.5	99.0
Type	0.08	0.13	0.002	0.003	0.01	0.80	99.7

## All Weld Metal Mechanical Properties

	R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	-	-	-	-
Max	-	-	-	-
Type	-	>380	-	-

## Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175: I1 (Ar) : 5-10 l/min I3 (Ar+He) : 5-10 l/min

FT En-TZ01-161208

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