TIGINOX

SOLID STAINLESS STEEL WIRES FOR TIG WELDING

TIGINOX FOR TIG WELDING		Typical Wire Chemistry							Typical Weld Metal Properties with 100% Ar gas shielding				Sizes (Dia.mm) :
									Typical mechanical properties of All-weld metal in As-welded condition				1.2, 1.6, 2.0, 2.5 (In 1000 mm length)
											CVN Impact		
BRAND	AWS Classification	C	Mn	Si	Cr	Ni	Mo	Nb	U.T.S Mpa	%E (4d)	Temp deg C	J	
TIGINOX 308	ER 308	0.045	1.60	0.40	20.0	10.0	–	–	650	36	-60	50	Also available Sizes: 0.8, 1.0, 1.2 (In 5 Kg. Spools)
TIGINOX 308L	ER 308L	0.022	1.60	0.40	20.0	10.0	–	–	620	40	-196	60	
TIGINOX 347	ER 347	0.04	1.50	0.40	20.0	10.0	–	0.50	640	37	-60	45	
TIGINOX 316	ER 316	0.045	1.50	0.40	19.0	12.0	2.50	–	650	34	-60	45	
TIGINOX 316L	ER 316L	0.025	1.50	0.40	19.0	12.0	2.50	–	620	38	-196	50	
TIGINOX 309	ER 309	0.04	1.50	0.45	24.0	13.0		–	620	38	-60	70	
TIGINOX 309L	ER 309L	0.026	1.50	0.45	24.0	13.0	–	–	600	40	-60	100	
TIGINOX 309Mo	ER 309Mo	0.04	1.50	0.45	24.0	13.0	2.50	–	640	38	-60	90	
TIGINOX 310	ER 310	0.10	1.50	0.45	26.5	21.0	–	–	590	43	–	–	
TIGINOX 312	ER 312	0.10	1.55	0.50	30.0	9.5	–	–	680	23	–	–	Note : The properties mentioned will vary with the type of shielding gas used.
TIGINOX 410	ER 410	0.08	0.45	0.35	12.5	–	–	–	530*	23*	–	–	
TIGINOX 430	ER 430	0.06	0.45	0.35	16.5	–	–	–	550**	23**	–	–	

Note: The properties mentioned above will vary with type of shielding gas used

*-After PWHT of 1 hour at 745 deg C, furnace cooled to 315 deg C and then cooled in still air.
**- After PWHT of 2 hours at 775 deg C, furnace cooled to 595 deg C and then cooled in still air.