TIG 20/10T

Old reference: TIG 321

Classification

ISO 14343-A : W Z 19 9 Ti
AWS A5.9 : ~ER321

Material N° : 1.4541

Description & Applications

Solid rod for TIG welding of stabilised stainless steels (321…) or low carbon content stainless steels (304L…). Good intergranular resistant corrosion. The TIG process is particularly suited for welding of piping systems, works of fine thinness equal or inferior than 3 mm.

Main applications: Aeronautical industry.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Ti	P	S	Fe
0.03	0.5	1.5	18.0	10.5	0.3	0.3	0.2	<0.03	<0.02	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
460	630	35	+20°C 110

Welding Current & Instructions

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

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