TIG 819 BS

Classification

EN 14700 : S Fe3 Material N° : 1.6773

Description & Applications

Solid rod for TIG welding and hardfacing. Product of high purity for welding without micro porosity.

Main applications: To repair and to surface the parent material 36NiCrMo16, 1.6773. Used for cold working tools, swages for forging and punching tools as well as for moulds for plastics.

Available copper coated or bare.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	P	S	Fe
0.35	0.3	0.4	1.7	3.8	0.3	<0.015	<0.010	Rem.

All Weld Metal Mechanical Properties

Hardness
~48 HRC

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min

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