TIG F66S

Classification

AIR 9117 : 25CD4

Description & Applications

Solid rod for TIG welding of steels such as 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	Ni	P	S	Fe
0.23	0.2	0.7	1.2	0.2	0.15	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	Hardness
750 Depending on heat treatment	880-1080 Depending on heat treatment	12	46 HRC

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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