Selectarc WELDING

SELECTARC TIG F77

Old reference : TIG 100S1

Classification

AWS A5.28 : ER100S-1 ISO 16834-A : W Z Mn3Ni1.5Mo

Approvals : CE

Characteristics

GTAW copper coated wire electrodes to weld high strength steels with Rm upto 800 Mpa (Re upto 690MPa)

Applications

Used for General metal constructions, Blacksmithing, Ship building etc. Also used as Buffer or Build up layer before hardfacing. Fine grain and cold tough steels.

Base Materials

NF A 36 -204	E 500T* , E 620T* , E 690T*.
DIN 17102	StE 590*, StE 690*, TStE 500* , WStE 500*. 17MnCrMo 33, 11 NiMnCrMo55 , 16 NiCrMo 12, 12MnNiMo 55.
Werstoff Nr.	1.8928* - 1.7279*- 1.6780* - 1.6343* etc
ASTM	A517 - A533Gr. A - A537 - A678 - A633 Gr. C bis E N-A XTRA ; N-A XTRA70* (Thyssen.)
Tube Steels	Apl 5 LX ; X70* , X75* , X80*

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P	Fe
0.08	0.50	1.50	0.15	1.60	0.35	0.010	0.012	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS Rm (MPa)	YS Re (MPa)	% Elg A_5	Impact (KV) Temp.°C	J
AW	820	730	19	-51	70

Welding Current & Instructions

Welding Mode	Shielding Gas
TIG = -	Ar : 6 - 12 l/min Back shielding : N_2/H_2 : 3 - 6 l/min

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