

HAS 59

TIG (GTAW)

SOLID ROD FOR TIG

PRODUCT DESCRIPTION

Solid rod for TIG

CLASSIFICATIONS

AWS A5.14M ERNiCrMo-13
ISO 18274 SNi6059

ASME IX QUALIFICATION

QW432 F-No 43

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Fe	Co	Al
Min.	--	--	--	--	--	22.0	56.0	15.0	--	--	0.1
Max.	0.010	0.5	0.10	0.005	0.015	24.0	Bal	16.5	1.5	0.3	0.4
Typical	0.003	0.2	0.03	0.003	0.003	23	60	15.6	0.4	0.1	0.3

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical
Tensile strength (MPa)	730
0.2% proof strength (MPa)	510
Elongation (%) 4d	34
5d	32
Impact ISO-V(J) +20°C	140
Hardness HV	240

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon*	DC-	2.4	100A, 12V

* Also required as a purge for root runs.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	2.5	PE TUBE	THAS59-16
2.0	2.5	PE TUBE	THAS59-20
2.4	2.5	PE TUBE	THAS59-24
3.2	2.5	PE TUBE	THAS59-32