

## HAS C22

TIG (GTAW)

## SOLID ROD FOR TIG

## PRODUCT DESCRIPTION

Solid rod for TIG

## CLASSIFICATIONS

AWS A5.14M      ERNiCrMo-10  
ISO 18274      S Ni 6022

## ASME IX QUALIFICATION

QW432      F-No 43

## CHEMICAL COMPOSITION (WIRE WT %)

|         | C     | Mn   | Si   | S     | P    | Cr   | Ni   | Mo   | W   | V    | Co  | Cu   | Fe  |
|---------|-------|------|------|-------|------|------|------|------|-----|------|-----|------|-----|
| Min.    | --    | --   | --   | --    | --   | 20.0 | 49.0 | 12.5 | 2.5 | --   | --  | --   | 2.0 |
| Max.    | 0.01  | 0.50 | 0.08 | 0.010 | 0.02 | 22.5 | --   | 14.5 | 3.5 | 0.3  | 2.5 | 0.50 | 6.0 |
| Typical | 0.003 | 0.2  | 0.03 | 0.002 | 0.01 | 21   | 56   | 13.5 | 3   | 0.15 | 1.5 | 0.1  | 4   |

## ALL-WELD MECHANICAL PROPERTIES

| As welded                 | Typical |
|---------------------------|---------|
| Tensile strength (MPa)    | 740     |
| 0.2% proof strength (MPa) | 500     |
| Elongation (%) 4d         | 44      |
| 5d                        | 42      |
| Impact ISO-V(J) -196°C    | 130     |
| Hardness (HV)             | 220     |

## 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   | THASC22-16  |
| 2.0           | 2.5         | PE TUBE   | THASC22-20  |
| 2.4           | 2.5         | PE TUBE   | THASC22-24  |
| 3.2           | 2.5         | PE TUBE   | THASC22-32  |