

TIG RODS FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- STG-50 is a tig rod for 490N/mm² grade steel.
- It is used for ship building, pressure vessel, vehicles, petro chemical, pipes of nuclear plant and other high pressure equipment.

NOTE ON USAGE :

- Use 99.997% Ar as shielding gas and control the gas flow properly, 100~200Amp with 7~12 l/min; 200~300Amp; 12~15 l/min.
- Recommended E.S.O. 5mm and arc length is 1~3mm for better bead appearance.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (Shielding Gas : Ar)

C	Mn	Si	P	S
0.07	1.51	0.78	0.013	0.006

TYPICAL MECHANICAL PROPERTIES OF WELD METAL : (Shielding Gas : Ar)

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -30°C /-45°C J(Kgf-m)
470(48.0)	550(56.1)	30	220(22.4)/150(15.3)

SIZE AND RECOMMENDED CURRENT RANGE : DC(-)

Diameter(mm)	1.2	1.6	2.0	2.4	3.2	4.0
Current (Amp)	60-80	70-90	90-120	100-140	160-250	180-280