

TIG RODS FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- STG-56 is a tig rod for 490N/mm² grade steel. Especially for the first backing welding of pipe.
- 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.
- In order to avoid porosity defect, proper protection from wind during welding.

WELDING POSITION :



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

C	Mn	Si	P	S
0.09	1.44	0.88	0.014	0.009

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)
461(47.0)	570(58.2)	28	240(24.5)/160(16.3)

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