BÖHLER BW XII

TIG rod for gas welding, unalloyed

Classifications

EN 12536	AWS A5.2	AWS A5.2M
O III	R60-G	RM40-G

Characteristics and typical fields of application

Gas welding rod, nickel alloyed. Easy to operate due to very easy weld pool and slag control and good gap bridging ability.

Weld pools are not susceptible to overheating when welded with a too hot flame.

Base materials

Steels up to a yield strength of 275 MPa (40 ksi)

S235JR - S275JR, P195GH-P275GH, L245NB-L290NB, L245MB-L290MB

ASTM A 29 Gr. 1013, 1016; A 283 Gr. C, D; A 510 Gr. 1013, A 711 Gr. 1013, A 501 Gr. B; A 512 Gr. 1021; A 513 Gr. 1016, 1021; A 572 Gr. 42, 65; A 633 Gr. A, C: A 659 Gr. 1016; A 709 Gr. 36, 50

Typical analysis of the TIG rods (wt.-%)

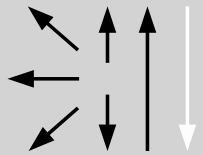
	C	Si	Mn	Ni
wt.-%	0.1	0.15	1.1	0.45

Mechanical properties of all-weld metal

Condition	Yield strength R_e	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
u	≥ 275	≥ 410	≥ 14	≥ 47

u untreated, as welded

Operating data



Rod marking:

front: O III

back: 1.6215

ø (mm)

2.0

2.5

3.0

4.0

Approvals

TÜV (02323.), DB (70.014.01), CE