

# INERTFIL 24 12 nC

Drôt pre zváranie MAG/TIG

Welding rod/wire electrode for TIG/MAG-welding process

Pręty/druty do spawania metodami TIG/MAG



## Standards:

DIN EN 12072

DIN 8556

AWS/ASME SFA-5.9

Comparable No. of Materials:

G 23 12 L

SG X 2 Cr Ni 24 12

ER 309 L

1.4332

## SK Vlastnosti a použitie:

Austeniticko-feritický zvärací drôt v L kvalite (veľmi nízky obsah uhlíka) pre zváranie vysoko legovaných ocelí s nelegovanými a nízkoaloyovanými metódou TIG a MAG pre prevádzkové teploty 300 °C. Pri vyšších prevádzkových teplotách použít NIFIL 600.

## GB Applications and properties:

Austenitic-ferritic welding rod or wire electrode in ELC-quality for TIG/MAG-welding of high-alloy steels to unalloyed or low-alloy steels, subject to operating temperatures up to 300 °C. For higher operating temperatures use NIFIL 600 consumables.

## POL Zastosowania i własności:

Austenityczno-ferytyczne pręty do spawania lub druty klasy ELC do spawania stali wysokostopowych z niestopowymi lub niskostopowymi, pracującymi w zakresie temperatur do 300°. Przy wyższych temperaturach roboczych należy stosować materiały spawalnicze NIFIL 600.

## Materials:

Joint welding of alloy steels		Dissimilar joints alloyed to unalloyed	
No. of Materials	EN-Designation	No. of Materials	EN-Designation
1.4583	S(P)275 bis S(P)355	1.4571	P295GH, 16Mo3

## Approvals:

TÜV

## Rod and wire analysis correspond to all-weld metal analysis (typical values in %)

C	Si	Mn	Cr	Ni	P	S
0,020	0,45	1,80	24,00	13,00	≤0,030	≤0,020

## Mechanical properties of all-weld metal (single values are typical values):

Heat treatment	0,2 % Proof stress [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation A <sub>5</sub> [%]	Impact energy ISO-V [J]
				+20 °C
AW	≥350	≥520	≥30	≥47

AW = as-welded

Analysis and mechanical properties apply to the use of shielding gas:

DIN EN 439 - I1 in TIG – welding

DIN EN 439 - M13 in MAG – welding

## Shielding gas acc. to DIN EN 439:

Welding rod for TIG-welding:

I1 (ARCAL 1)

Wire electrode for MAG –welding:

M12 (ARCAL 12), M13 (INARC S 3), M21 (ARCAL 21)

Consumption:

TIG = approx. 10 l/min, MAG = approx. 15 l/min

## Form of delivery:

Welding rods			
Dia. [mm]	2,0	2,4	3,2
Length [mm]	1000		
Approx. Weight of packet [kgs]	10		
Wire electrodes			
Dia [mm]	0,8	1,0	1,2
Wire cage reel K300 [kgs]	15		

Further forms of delivery on request.

## Type of current/Polarity/Welding positions:

