


ATEST PÉDAN. P.AT.

DQ 01/ 45273W		Technical Data Reference Document TIG - Filler rod		Rev. 0 Page 01 Date 2000-09-11																																													
<b>Designation:</b> CastoTig 45273W <b>General description:</b> Cu-coated filler rod for Mo-alloyed, high temperature constructional steels and fine grain steels <b>Service temperature [°C]:</b> min. - 20°C; max. 550°C <b>Hardening [°C]:</b> 910 - 940°C (Oil) <b>Tempering [°C]:</b> 660 - 770 °C																																																	
<b>Standard</b> DIN 8575: WSG Mo W.Nr.: 1.5424 AWS A5.28: ER80S-G																																																	
<b>Chemical composition [w.-%] according to EN 12070:</b> <table border="1"> <thead> <tr> <th></th> <th>C</th> <th>Mo</th> <th>Si</th> <th>Mn</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>typical</td> <td>0,1</td> <td>0,5</td> <td>0,7</td> <td>1,1</td> <td>bal.</td> </tr> </tbody> </table>						C	Mo	Si	Mn	Fe	typical	0,1	0,5	0,7	1,1	bal.																																	
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<b>Properties</b> as welded (+20°C) typical after hardening typical																																																	
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<b>Shielding gases:</b> EN 439 - I1 (100 % Ar) <b>Approvals:</b> TÜV, DB (42.024.06), Ü <b>Marking:</b> 1. side "E+C 45273W", 2. side "1.5424"																																																	
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<b>Welding position</b> PA, PB, PC, PD, PE, PF <b>Current/Polarity</b> =/-																																																	
<b>Technical delivery conditions according to EN 759</b>																																																	
<b>Special conditions:</b> pre-heating and interpass temperature max. 200°C stress relieving: 530 - 620°C carbon case hardenable Observe the national standards and MSDS's																																																	
		<b>ASSURANCE QUALITÉ QUALITÄTSSICHERUNG QUALITY ASSURANCE</b>		Prepared by: O.Penning, 27.12.99  Appr.AQ by: NO, DRAFT																																													