

PRODUCT INFORMATION

SIFSTEEL No 22

BS EN 12536: 2000 011

DESCRIPTION

A special alloy steel rod containing manganese for toughness. It provides a weld deposit of high strength and ductility. Recommended for oxy/acetylene welding of steel pipelines and pressure vessels, but can also be used with TIG in suitable applications.

WELDING POSITIONS



Suitable for use in heating and ventilation, offshore and ship building industries, particularly for welding pressure vessels.

TYPICAL WELD METAL COMPOSITION

C	0.1 %
Si	0.1 %
Mn	1.1 %

TYPICAL MECHANICAL PROPERTIES

Melting Point	1450 °C
Ult Tensile Strength	450 N/mm ²
Hardness	140

MATERIAL TO BE WELDED

This is our special low carbon alloy steel rod containing 1.5% manganese for toughness, and providing a deposit metal of high strength and ductility. Recommended for welding pipe lines, pressure vessels and for use on fabrications which require where reliable high strength joints are required.

AVAILABLE FORMATS

1M ROD (TIG / GTAW)			
Dia			5.0kg Ctn
1.6mm			RO221650
2.5mm			RO222550
3.0mm			RO223050

Process:	Oxy/Acetylene Gas Welding
TIG:	DC =+
Amps:	60-140
Gas:	Pure Argon

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email service@wholeweld.co.uk

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