

Solid wires for heat-resistant, low-alloy steel

Product Name	Specification		Shield gas	Application and features
	JIS	AWS		
TGC-2CM	YGT-2CM	ER 90S-B3	Ar	For welding of 2.25%Cr-1%Mo steel.

Solid wires for Nickel and Nickel alloy

Product Name	Specification		Shield gas	Application and features
	JIS	AWS		
TGC-Ni1	Y Ni-1	ER Ni-1	Ar	Repair welding of cast iron, cladding of carbon steel, stainless steel, dissimilar welding of MONEL, CUPRO Nickel
TGC-182	Y NiCr-3	ER NiCr-3	Ar	Dissimilar welding of INCONEL(600), stainless steel, INCONEL and carbon steel, nickel alloy.
TGC-625	Y NiCrMo-3	ER NiCrMo-3	Ar	For welding of INCONEL 625, dissimilar welding of INCONEL AND Nickel alloy, for 9%Nickel steel, high temperature and low temperature steel.
TGC-NiCu7	Y NiCu-7	ER NiCu-7	Ar	MONEL 400, dissimilar welding of MONEL and carbon steel, cladding of carbon steel.
TGC-690	-	ER NiCrFe-7	Ar	INCONEL 690, dissimilar welding of INCONEL, INCOLOY alloy, cladding of low alloy steel.
TGC-CuNi3	Y CuNi-3	ER CuNi	Ar	70%Cu-30%Ni CUPRO nickel, dissimilar welding of CUPRO nickel and copper alloy, cladding of carbon steel.

Solid wire for hardfacing (Stellite)

Product Name	Specification	Shield gas	Application and features
	AWS		
CST6R	RCoCrA	Ar	For welding of valve seats, forging dies, crushers and screw.

Dia. (ømm)	Typical chemical composition of Weldin Rod (%)							TS of weld metal N/mm ² (kgf/mm ²)	Tip color
	C	Mn	Si	P	S	Cr	Mo		
1.2 1.6 2.0 2.4 3.2	0.1	0.6	0.5	0.006	0.004	2.36	1.1	780(80)	-

Dia. (ømm)	Typical chemical composition of Weldin Rod (%)														Typical mechanical properties		Approval
	C	Mn	Si	P	S	Ni	Cu	Ti	Cr	Nb	Mo	Al	Fe	Pb	TS N/mm ² (kgf/mm ²)	EL (%)	
	0.02	0.39	0.43	0.001	0.002	95.5	0.02	2.50	-	-	-	0.06	0.15	-	510	40.6	-
	0.01	3.20	0.10	0.002	0.002	72.9	0.01	0.35	20.5	2.70	-	-	0.10	-	680	41	-
1.2 1.6 2.0 2.4 3.2	0.02	0.01	0.03	0.002	0.001	64.1	0.01	0.20	22.3	3.60	9.20	0.10	0.30	-	790	38	-
	0.09	3.10	0.18	0.005	0.003	65.0	REM	1.61	-	-	-	0.02	0.11	-	570	38	-
	0.02	0.25	0.17	0.004	0.001	REM	0.01	0.53	28.9	0.02	0.01	0.68	10.25	-	690	40	-
	0.03	0.54	0.03	-	0.003	31.1	67.24	0.29	-	-	-	0.01	0.54	0.02	374	36.3	-

Dia. (ømm)	Typical chemical composition of Weldin Rod (%)						-
	C	Si	Mn	Cr	W	Co	
3.2 4.0 5.0 6.0	1.13	1.09	0.49	30.38	4.54	Balance	-