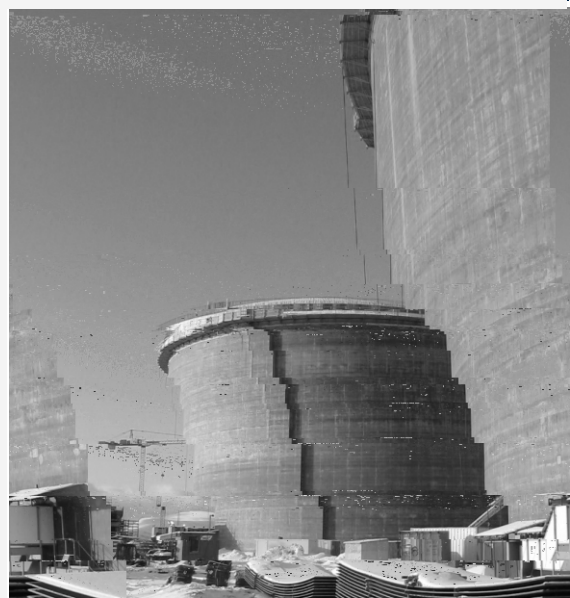




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TIENTAI ELECTRODE

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**WELDING CONSUMABLES
IN INDUSTRY**



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CROMAROD
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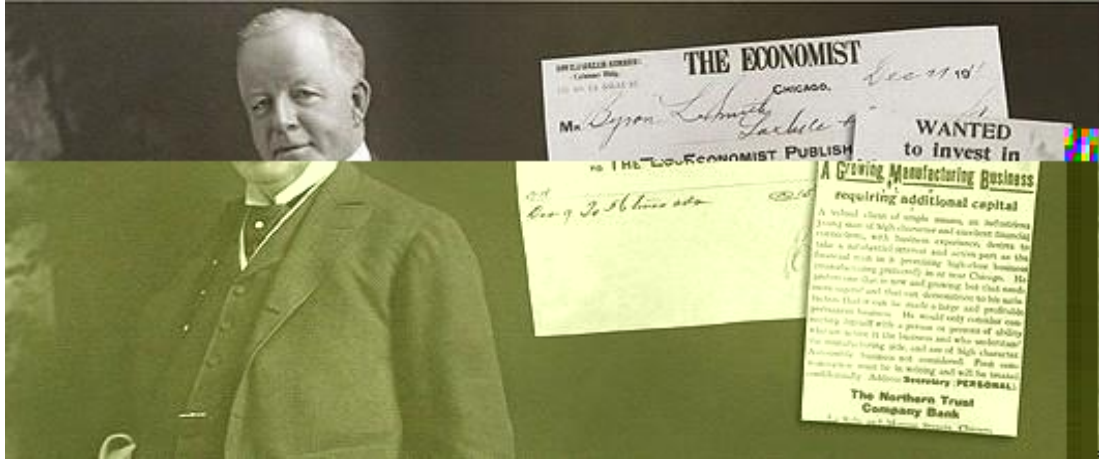
HIGH
PRODUCTIVITY
AND RELIABLE
END-RESULTS



QUALITY
& KNOW-HOW
IN WELDING



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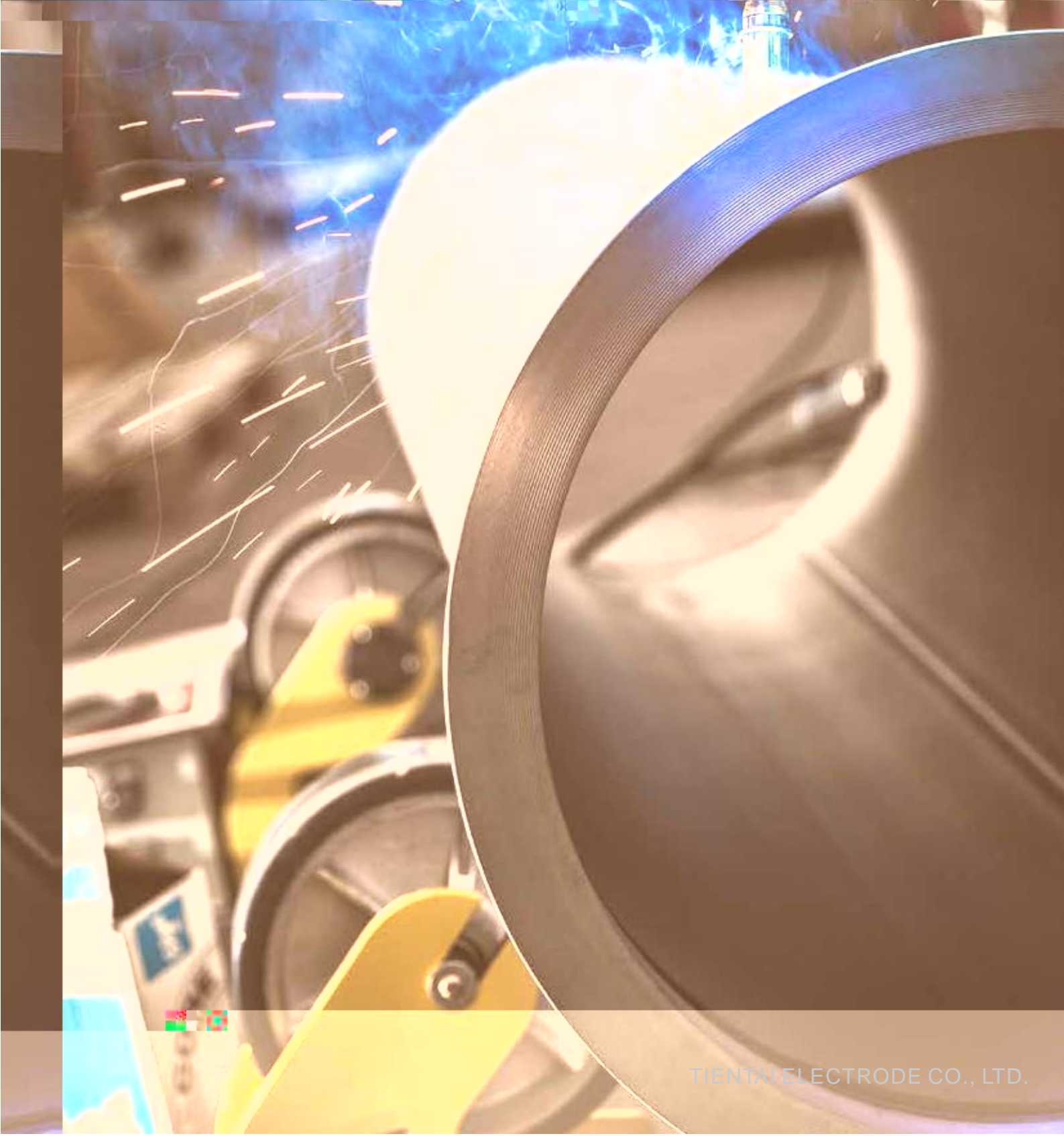
(wt%):

SMAW	TN-18	550(80)	650(94)	30	60(44)	-46(-51)
	TN-28	550(80)	630(91)	30	70(52)	-60(-75)
	TN-	()	6 ()		5()	- (-1)
	TNM-9	-	700(102)	43	70(52)	-196(-320)
FCAW	TWE-811Ni1	602(87)	650(94)	26	110(81)	-30(-20)
					95(70)	-40(-40)
	TWE-81K2	580(84)	635(92)	26	75(60)	-60(-76)
	TFW-5T	410(57)	600(87)	36	80(64)	-110(-166)
	TFW-625	500(73)	790(115)	36	70(52)	-196(-320)
SAW	TF-570/TSW-12KM	428(62)	519(75)	34	327(240)	-40(-40)
	TF-210/TSW-E33	486(70)	581(84)	30	64(47)	-101(-150)
	TF-210/TSW-E40	468(68)	562(82)	33	108(80)	-62(-80)
	TF-210/TSW-12KH	462(678)	550(79)	30	150(111)	-60(-75)
	TFS-340/TW-17	490(71)	718(104)	40	85(63)	-196(-320)



				(%)	ISO-V J	°C
9Ni	X7Ni9	>585	680-820	>18	>100	-196
	X8Ni9	>585		>18	>70	
	A353	>515	690-825	>20	>34	
	A553	>585		>20	>34	
5Ni	X12Ni5	390	530-710	20	47	-110
3.5Ni	A203 Gr, D-E	355	490-620	22	27	-100
	12Ni14					
2.5Ni	A203 Gr, A-B	275	480-620	22	27	-80
1.5Ni	15NiMn6	355	490-640	22	27	-80
0.5Ni	11MnNi5-3	285	420-530	24	40	-60
	13MnNi6-3	355	490-610	22	27	-60
	P355 QL1	355	490-630	22	27	-40
	P355 QL2					-60
	A537 CL1	345	485-620	22		-40
	A537 CL2	415	550-690	22	27	-60
		240	415	17	27	-30
	A516 Gr.70	260	485-620		27	-30
	A283 Gr.C	205	380-515	25	-	-30
	A240 Tpye 304L mod	240	550min		27	-196

		SMAW	FCAW	SAW
9Ni	X7Ni9	TNM-9	TFW-625	TFS-340*TW-17
	X8Ni9			
	A353			
	A553			
5Ni	X12Ni5	TNM-9	TFW-625 TFW-5T	TFS-340*TW-17
3.5Ni	A203 Gr, D-E	TN-	TFW-5T	TF-210*TSW-E33
	12Ni14			
2.5Ni	A203 Gr, A-B	TN-	TFW-5T	TF-210*TSW-E3
1.5Ni	15NiMn6	TN-	TFW-5T	TF-210*TSW-E3
0.5Ni	11MnNi5-3	TN-28	TWE-81K2	TF-210*TSW-E40
	13MnNi6-3	TN-28	TWE-81K2	TF-210*TSW-E40
	P355 QL1	TN-18	TWE-811Ni1	TF-210*TSW-E40
	P355 QL2	TN-28	TWE-81K2	TF-210*TSW-E40
	A537 CL1	TN-18	TWE-811Ni1	TF-210*TSW-E40
	A537 CL2	TN-28	TWE-81K2	TF-210*TSW-E40
		TL-581	ArcStar T12	TF-210*TSW-12KH
	A516 Gr.70	TL-50	TWE-711	TF-570*TSW-12KM
	A283 Gr.C	TL-50	TWE-711	TF-570*TSW-12KM
	A240 Tpye 304L mod	TS-308LB	TFW-308L	TFS-300*TW-308L



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