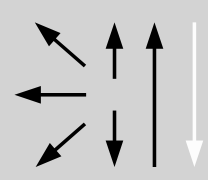


Classifications				
EN 12536	AWS A5.2	AWS A5.2M		
O I	R45-G	RM30-G		
Characteristics and typical fields of application				
Copper coated, unalloyed rod for gas welding for joints subject to normal stresses up to base metal grade S275 JR. Fluid weld puddle.				
Base materials				
Steels up to a yield strength of 235 MPa (34 ksi) S235JR, P195TR1-P235TR1 ASTM A 29 Gr. 1013; A 510 Gr. 1013, A 711 Gr. 1013				
Typical analysis of the TIG rods (wt.-%)				
	C	Si	Mn	
wt.-%	0.08	0.1	0.6	
Mechanical properties of all-weld metal				
Condition	Yield strength R_e	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
u	≥ 235	≥ 340	≥ 14	≥ 35
u untreated, as-welded				
Operating data				
	Rod marking: front: ✦ O I back: 1.0324		∅ (mm)	
			2.0	
			2.5	
			3.2	
		4.0		
Approvals				
TÜV (06315.), LTSS, CE				