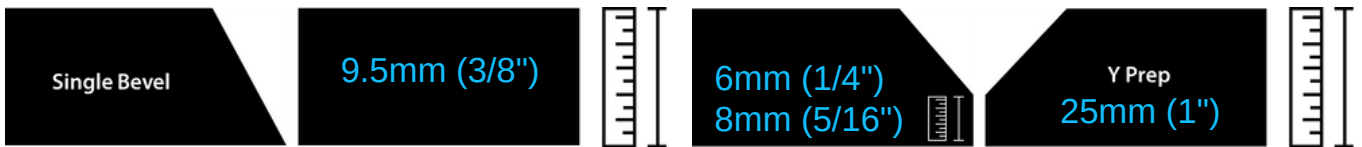


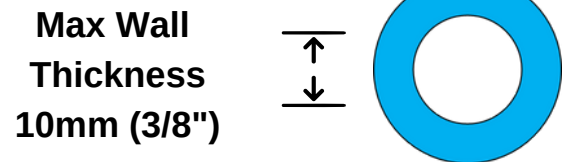
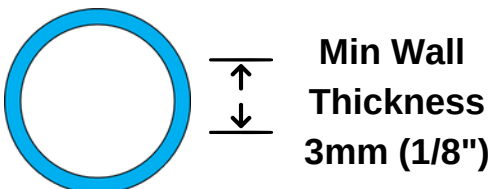
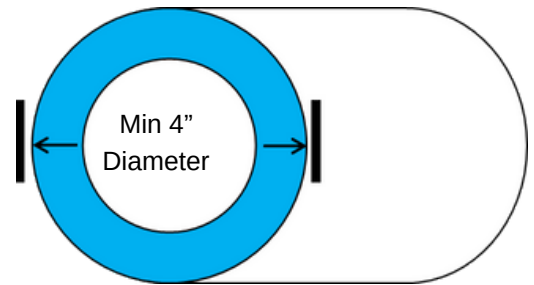
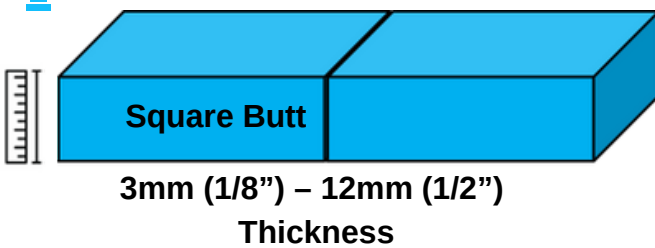
Austenitic Stainless Steel

The K-TIG Welding System uses conventional weld forces with a higher current (amps) to create a stable keyhole TIG weld.

Thickness Ranges Maximum 25mm (1")

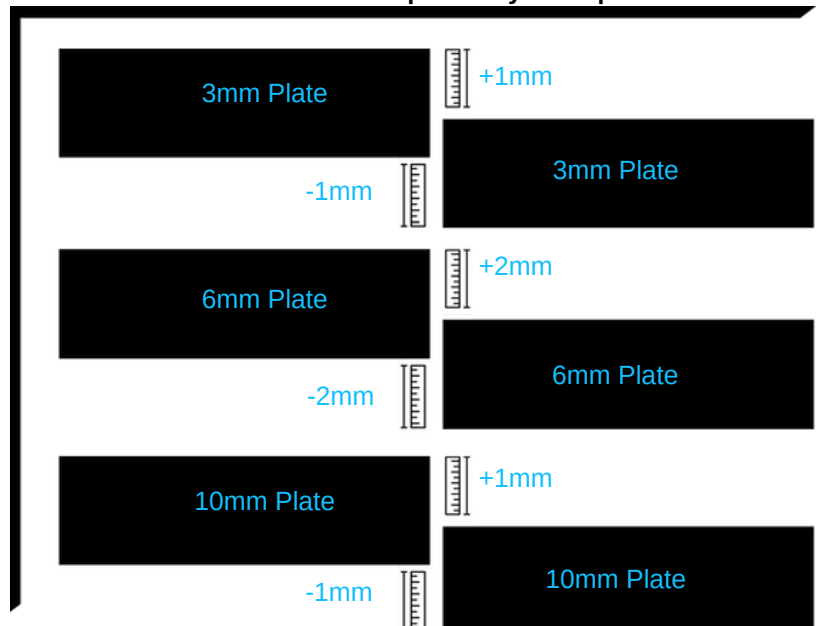
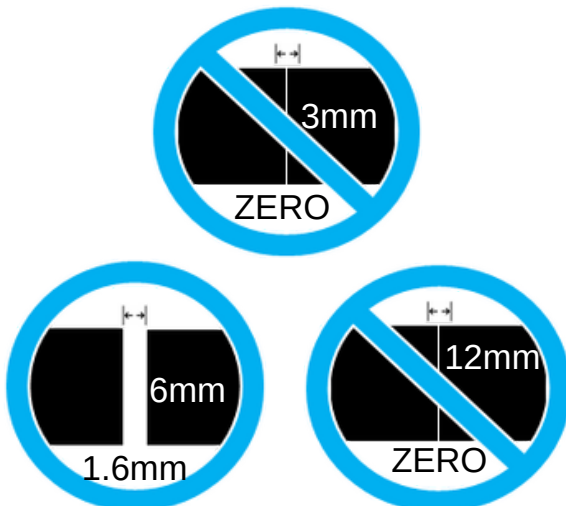


Capabilities



Gap Tolerances Cover pass may be required

Mismatch Tolerance Cover pass may be required



Sulphur Tolerances

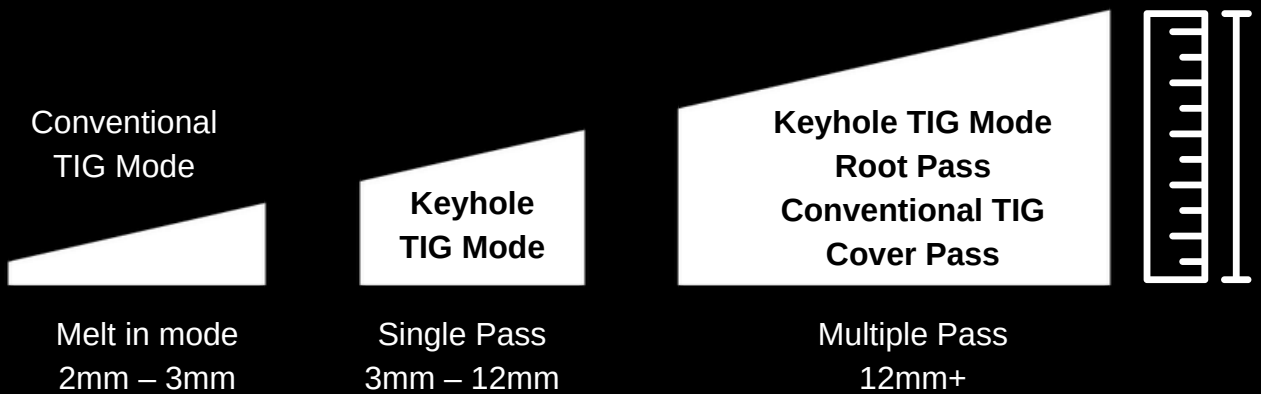
3mm - 0.005% / 6mm - 0.005% / 10mm - 0.003%

Material Information Guide

Austenitic Stainless Steel

Austenitic stainless steel is a type of stainless steel that contains high levels of nickel and chromium, along with other alloying elements such as manganese, nitrogen, and molybdenum. It is named after the austenitic microstructure that is formed when the steel is cooled from a high temperature.

Welding Modes

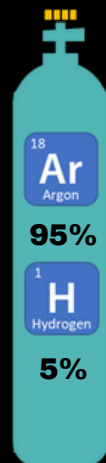


Guide to Average Travel Speeds

 200mm (8") per minute	 800mm (31.5") per minute
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Depending on material thickness and joint preparation

Torch Gas Mix



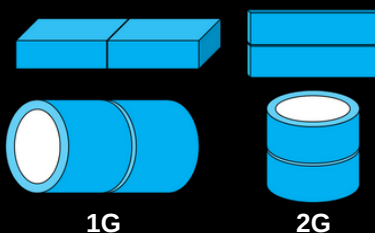
Gas is material dependant

Average Heat Inputs

Full Penetration Keyhole Pass

 0.33 Kj/mm (8.3 Kj/inch)	 1.5Kj/mm (38.1 Kj/inch)
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Cover passes/fill passes approx.
1 Kj/mm (25.4 Kj/inch)



Weld Positons



The values and ranges expressed within this document are intended as guide ranges only and should not be considered absolute values, as materials, equipment, applications and specific environment may impact individual performance