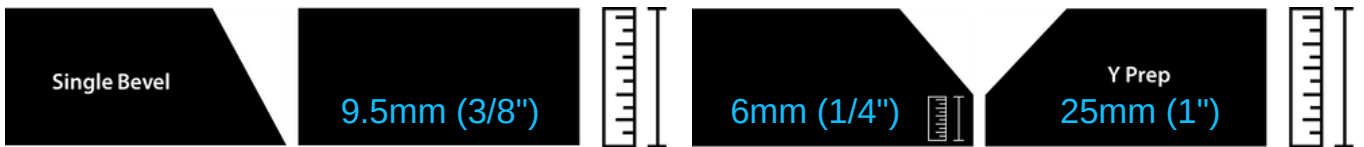


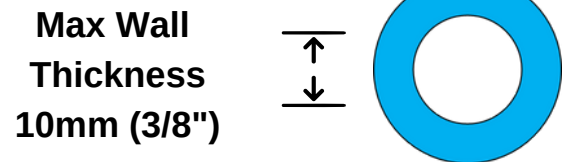
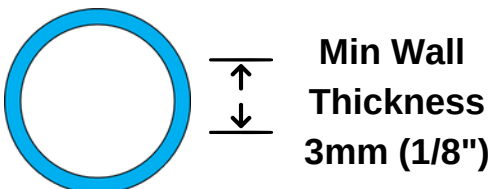
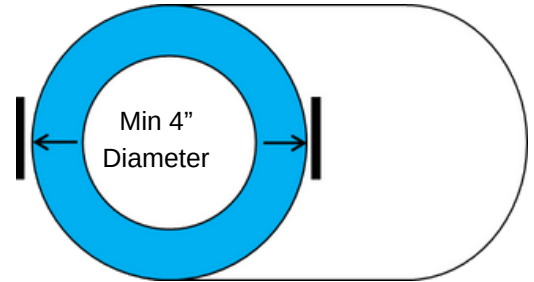
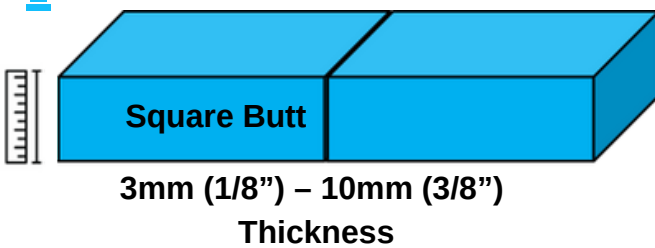
## Duplex / Super Duplex

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")

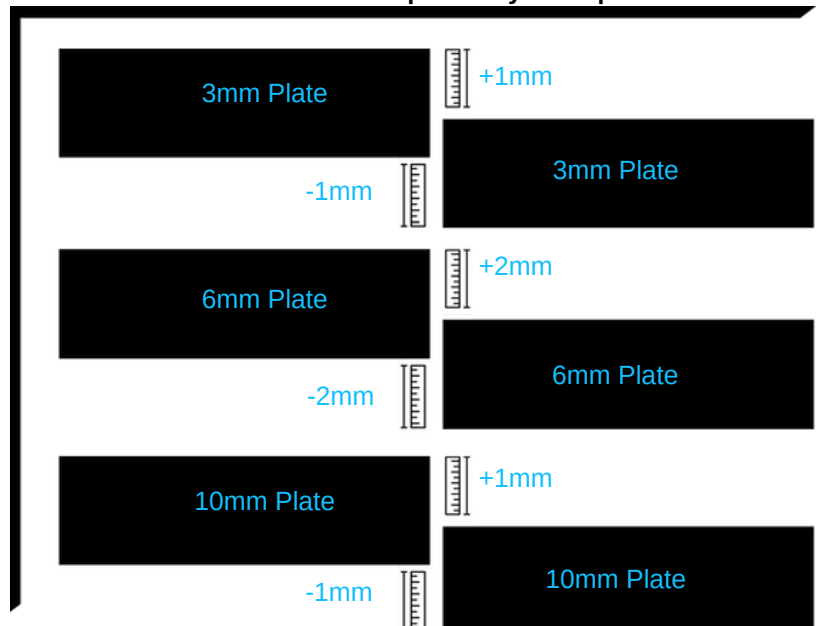
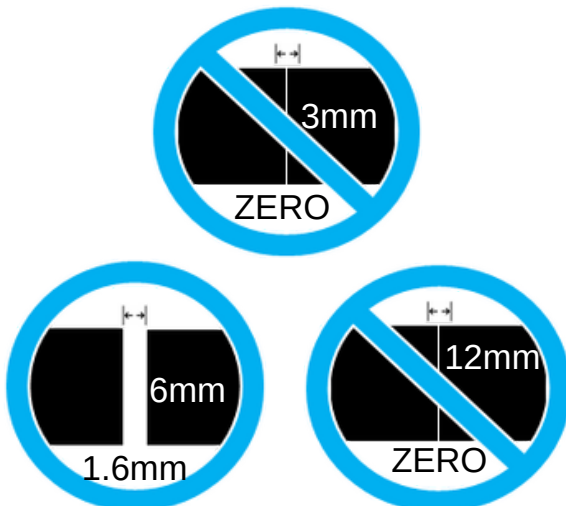


### Capabilities



### Gap Tolerances Cover pass may be required

### Mismatch Tolerance Cover pass may be required



### Sulphur Tolerances

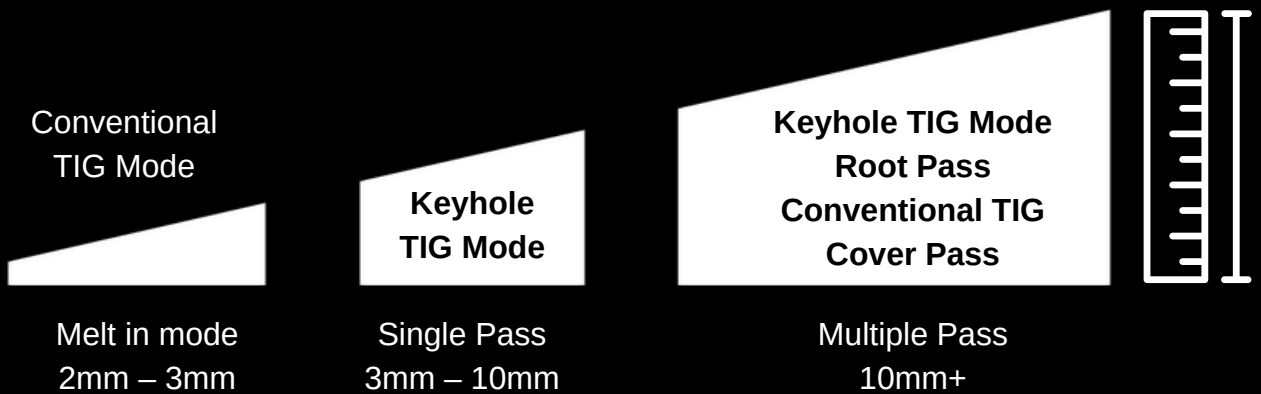
3mm - 0.005% / 6mm - 0.005% / 10mm - 0.003%

# Material Information Guide

## Duplex / Super Duplex

Duplex and super duplex steel are types of stainless steel that are known for their high strength and corrosion resistance. They are called "duplex" and "super duplex" because they contain a mixture of austenitic and ferritic microstructures, which provide them with unique properties.

### Welding Modes

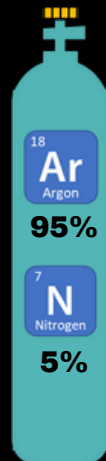


#### Guide to Average Travel Speeds

 200mm (8") per minute	 700mm (27.5") per minute
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Depending on material thickness and joint preparation

### Torch Gas Mix



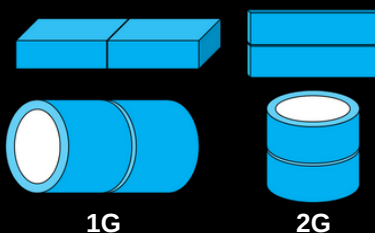
Gas is material dependant

#### 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