

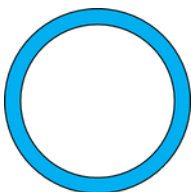
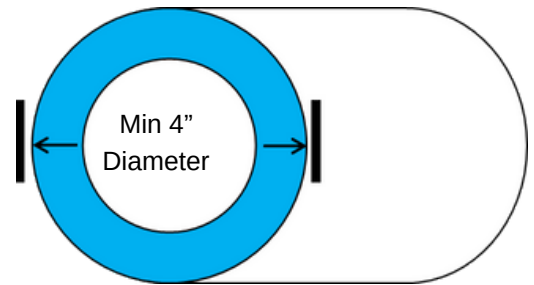
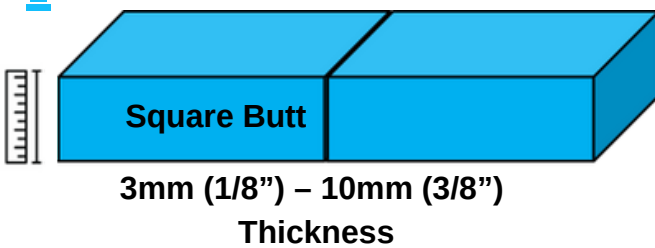
Nickel Alloys

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")

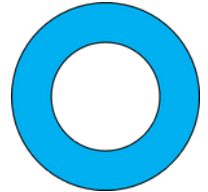


Capabilities



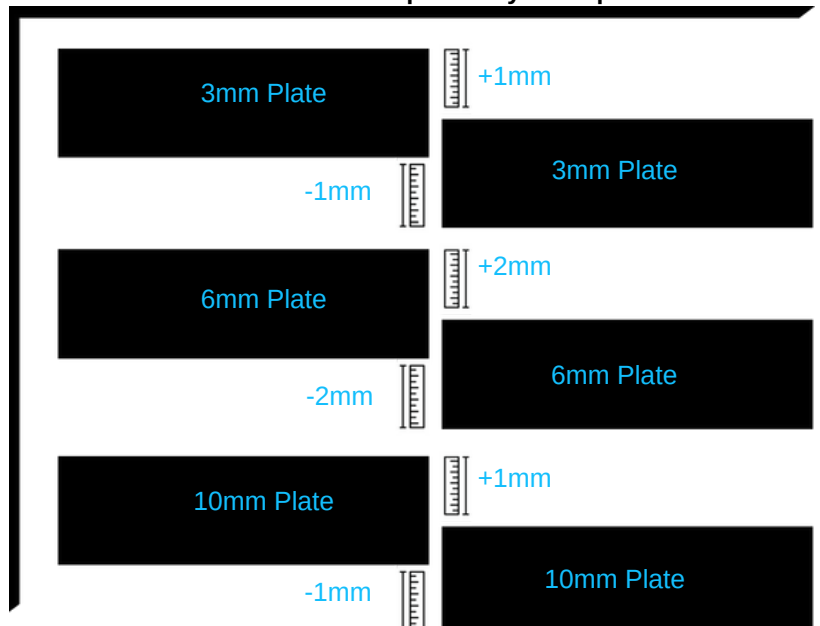
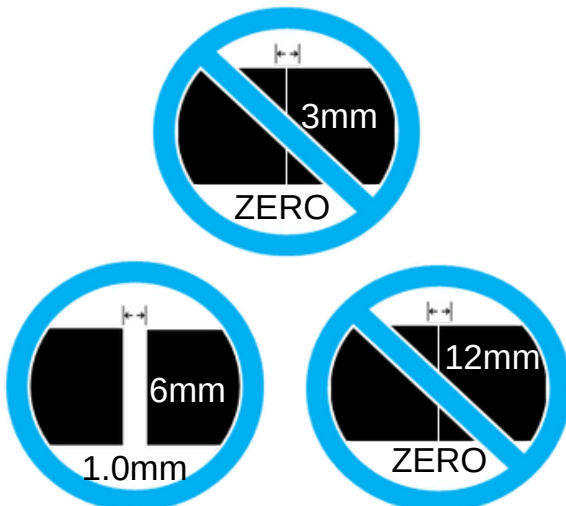
↑ Min Wall
↓ Thickness
3mm (1/8")

↑ Max Wall
↓ Thickness
10mm (3/8")



Gap Tolerances Cover pass may be required

Mismatch Tolerance Cover pass may be required



Sulphur Tolerances

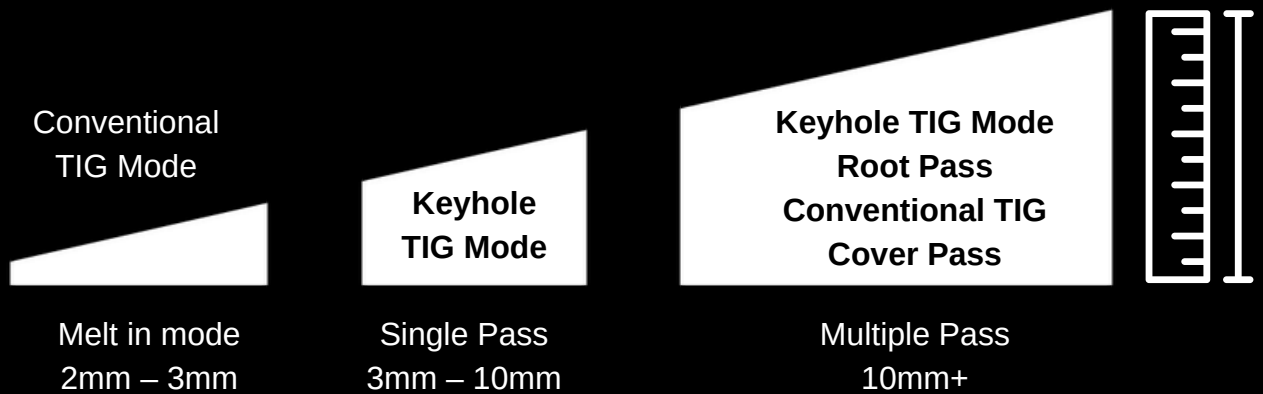
3mm - 0.005% / 6mm - 0.005% / 10mm - 0.003%

Material Information Guide

Nickel Alloys

Nickel alloys are a group of alloys that contain nickel as one of the primary components, along with other elements such as iron, copper, chromium, molybdenum, and others. Nickel alloys are known for their excellent corrosion resistance, high-temperature strength, and excellent mechanical properties.

Welding Modes

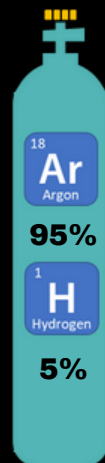


Guide to Average Travel Speeds

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

Torch Gas Mix



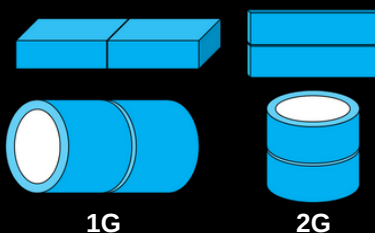
Gas is material dependant

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