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Table 1, thereby facilitating the consistently fine microstructure of the weld metal even in the as-cast or dendritic zone (**Figure 1**).

With higher heat input, the strength of the weld metal tends to decrease and the impact toughness is apt to be affected more largely by the testing temperature as shown in **Figure 3**. Hence, these factors should be controlled in welding procedures. Recommended preheat and interpass temperature is 150 . Recommended

How TGX filler rods can cut costs for gas purging and back shielding

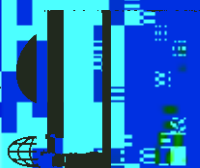
As discussed above, the use of a conventional solid filler rod requires back shielding normally with argon gas. Though the amount of argon gas and time for purging the inside of the pipe vary depending on the

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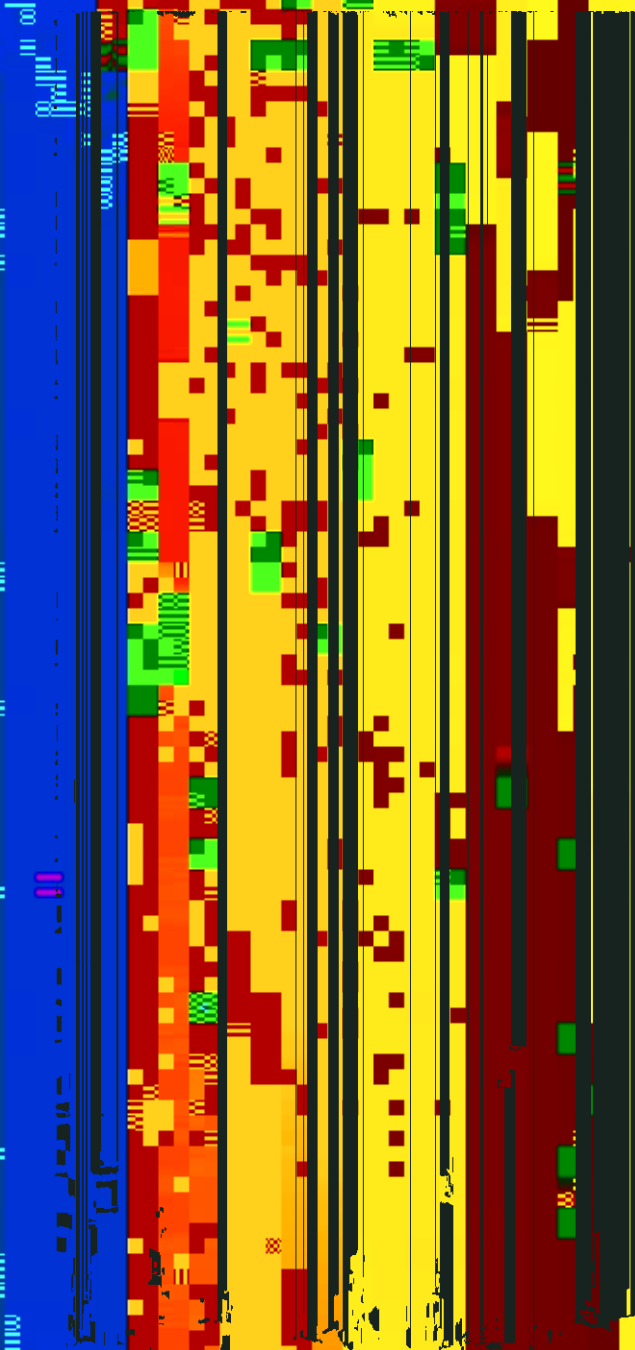
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