

## D-TIG

### High Quality + Productivity Cladding Solution by TIG

#### Twin Tungsten (D-TIG) Cladding for High Quality + Productivity

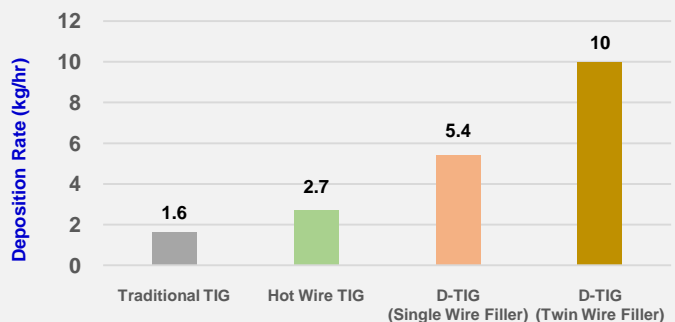
D-TIG uses two tungsten electrodes in a single specially designed water cooled TIG torch, which generates a powerful and wider arc resulting in higher metal deposition and lower penetration. The two tungsten electrodes are connected to two inter-connected TIG power sources with complimentary ON/OFF having master-slave configuration. Additional cold wire feeding may be used depending on the application to increase the deposition rate for delivering higher productivity. Thus D-TIG is a unique combination high quality TIG cladding of austenitic and martensitic stainless steel with higher productivity e.g. multiple times than what is achievable by the traditional TIG process.

#### Salient Features

- High quality – same as traditional TIG
- High productivity – up to 6 times higher than traditional TIG is achievable
- Precise control – two power sources are synchronized to achieve complimentary operation without any arc blow
- Wider arc – facilitates higher deposition with minimized dilution for delivering the desired cladding parameters
- Wire filler (option) – additional cold wire feeder(s) can be added to enhance the productivity further e.g. single / twin wire filler supplemented with D-TIG delivers a deposition rate 3.5 / 6 times higher than the traditional TIG respectively.



**D-TIG Cladding on Pipe ID**



**TIG Process for Cladding**

#### Application Segments

- Nuclear
- Pressure Vessels
- Oil and Gas
- Power Plant Equipment

#### Deposition Rates for Various TIG Cladding Processes

#	D-TIG System Configuration
1	2 x 500A DC TIG Power Sources (master-slave)
2	Weld Controller
3	TIG Torch with Twin Tungsten Electrodes
4	Water Cooling Unit
5	Control Connections
6	Fixture with Accessories for the System

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