

Fin materials

Almost every combination of tube and fin material can be welded. The most common materials are however:

ASME	ASTM	EN	fin thickness	fintip temperature
SA1008		1.0338 (DC04)	0.8mm up to 3.0mm	max. 490° C
	A240 TP410S	1.4000 (X6Cr13)	0.8mm up to 3.0mm	max. 650° C
	A240 TP409	1.4512 (X2CrTi12)	0.8mm up to 3.0mm	max. 650° C
	A240 TP304	1.4301 (X5CrNi18-10)	0.8mm up to 3.0mm	max. 850° C
	A312 TP316L	1.4404 (X2CrNiMo17-12-2)	0.8mm up to 3.0mm	max. 850° C
	A312 TP316 Ti	1.4571 (X6CrNiMoTi17-12-2)	0.8mm up to 3.0mm	max. 850° C
	A312 TP310S	1.4845 (X8CrNi25-21)	0.8mm up to 3.0mm	max. 1000° C