

TIG welding rod and wire

Features:	▪ Its tensile strength after long time PWHT is high enough for 490MPa
Classification:	AWS A5.18 ER70S-6
Shielding Gas:	Ar
Identification color:	1st Black
Polarity:	DCEN

Packaging data

φ mm	Spool		Tube		
	kg		kg	Length mm	g/piece
0.8	10		-	-	-
1.0	10		-	-	-
1.2	10		-	-	-
1.6	-		5	1,000	16
2.0	-		5	1,000	25
2.4	-		5	1,000	35
3.2	-		5	1,000	63
Volume mm	240W, 110H, 230L		40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty ^a
C	0.10	0.06~0.15
Si	0.86	0.80~1.15
Mn	1.56	1.40~1.85
P	0.012	0.025
S	0.012	0.035
Ni	0.01	0.15
Cr	0.02	0.15
Mo	<0.01	0.15
Cu	0.24	0.50
V	<0.01	0.03
Al	<0.01	-
Ti	<0.01	-
Zr	<0.01	-

Note: ^a Single values are maximum.**All-weld mechanical properties**

	Typical		Guaranty
0.2%YS (MPa)	510	420	400min.
TS (MPa)	610	550	483min.
El on 4d (%)	32	35	22min.
IV -29°C (J)	210	160	27min.
PWHT (°C×h)	AW	625x24	AW

Approvals

TÜV	DIN8559
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