

CARBON (AWS A/SFA 5.18) AND LOW ALLOY STEELS (AWS A/SFA 5.28) CONSUMABLES CLASSIFICATION FOR GTAW & GMAW

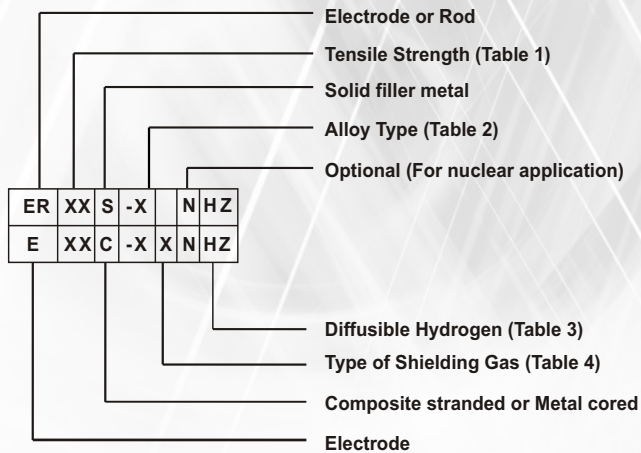


Table 1: Tensile Strength of undiluted weld metal

Code Digit	Tensile Strength min, psi (MPa)
70	70,000 (480) for 5.18
	75,000 (515) for 5.28
70 C-Ni2, 70 - G	70,000 (480)
80	80,000 (550)
90	90,000 (620)
100	100,000 (690)
110	110,000 (760)
120	120,000 (830)

Table 2: Alloy Type

Code Digit	Alloy Type*
2,3,4,6,7	C Steel
A1	C-Mo Steel
B2,B2L,B3,B3L, B6,B8,B9	C-Cr-Mo Steel
Ni1,Ni2,Ni3	C-Ni Steel
D2	C-Mn-Mo Steel
W2	Weathering Steel
K3,K4	Other Low Alloy Steel
'L' indicates Low Carbon Version	
*Refers to wire chemistry for 'S' grade and weld metal chemistry for 'C' grade	

Table 3: Diffusible Hydrogen

Code Digit	Diffusible Hydrogen Content, average (ml/100g Deposited Metal) max
H2	2
H4	4
H8	8
H16	16

Table 4: Type of shielding gas

Code Digit	Shielding Gas
C	Carbon dioxide
M	75-80% Argon- balance CO ₂



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