



# TIGFIL 70S-2

GTAW C-Mn Steel

AWS A/SFA 5.18 **ER70S-2**

### CLASSIFICATION:

EN ISO 636-A

W 42 3 2Ti

IS 6419

S4-I 504

### KEY FEATURES:

- Triple deoxidized copper coated C-Mn steel filler rod
- High quality, high toughness welds
- Excellent choice for welding over rust and mill scale
- Radiographic quality weld

**APPROVALS:** ABS/DNV/LRA/NPCIL/IBR/CE

### TYPICAL APPLICATIONS:

- Welding of Pressure vessel, Boilers involving unalloyed and micro-alloyed structural steels with specified UTS up to 520 MPa
- High quality pipe welding of mild and medium tensile steels
- Best suited for single side, melt through welding

### TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:


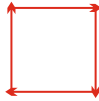
C	Mn	Si	Ti	Zr	Al
0.055	1.1	0.45	0.08	0.04	0.08

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	560	470	26	65

**Special Test:** Hot Tensile Test at 196°C / HIC and SSCC (NACE)

### PARAMETERS - PACKING DATA:

Ø x L, mm	Net Wt Kg/Box		
1.6 x 1000	20	 <b>DCEN</b> <b>STORAGE / HANDLING :</b> Keep dry during storage and handling	All Positions 
2.0 x 1000	20		
2.4 x 1000	20		
3.15 x 1000	20		

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.