



GTAW C-Mn Steel
TIGFIL 70S-6

C-Mn STEEL SOLID FILLER ROD



CLASSIFICATION : EN ISO 636-A AWS A/SFA 5.18 CSA W48 **APPROVALS :**

W 42 5 W3Si1 ER 70S-6 B-G 49A 3 C1 S6 CWB

KEY FEATURES :

- C-Mn steel filler rod
- Uniform copper coating
- Controllable weld pool
- Radiographic quality weld

WELDING POSITION : 



DCEN

Shielding Gas: Ar

Gas Flow Rate, LPM : 8-15

TYPICAL APPLICATIONS :

- Root pass pipe welding
- Thin sheet metal, Auto body
- Farm implements, Steel casings
- Collision repair, Pressure vessels
- Application in high pressure piping for shipbuilding, petro chemical and nuclear power plant

STORAGE / HANDLING :

Keep dry during storage and handling

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	S	P	Cu*
Specification	0.06-0.14	1.40-1.60	0.80-1.0	0.025 max	0.025 max	0.50 max

* Including Cu in the coating

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Specification	As Welded	500-640	420 min	22 min	27 min

PACKING DATA :

Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
1.6 x 1000	5	4	20
2.0 x 1000	5	4	20
2.5 x 1000	5	4	20