



Tigfil 70S-2 Spl

TRIPLE DEOXIDIZED COPPER COATED C-Mn STEEL FILLER ALLOY MEETS IMPACT AT -46°C

CLASSIFICATION : EN ISO 636-A

AWS A/SFA 5.18

APPROVALS :

W 42 5 W2Ti

ER 70S-2

ABS/BV/IBR

KEY FEATURES :

- Triple deoxidized C-Mn steel filler rod with very low impurities
- Uniform copper coating
- Strong, tough and ductile weld metal
- Meets impact requirement at -46°C
- Radiographic weld quality

WELDING POSITION :



DCEN

Shielding Gas: Ar

Gas Flow Rate, LPM : 8-15

TYPICAL APPLICATIONS :

- Welding NACE pipes- type A106 Gr.B or equivalent material
- Recommended for root runs of pipes and tubes for offshore application
- Pressure vessels, Boilers involving unalloyed and micro-alloyed structural steels with specified UTS upto 520 MPa

STORAGE / HANDLING :

Keep dry during storage and handling

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Ti	Zr	Al	Cu*	S	P
Specification	0.07 max	0.90-1.40	0.40-0.70	0.05-0.15	0.02-0.12	0.05-0.15	0.50 max	0.010 max	0.015 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 -46°C, J
Specification	As Welded	500 min	420 min	22 min	28 min

Hardness, 3 Layers : 210 BHN max

Diffusible H2 Content: <5 ml/100 gm

SPECIAL TESTS :

HIC and SSCC (NACE)

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
3.2 x 1000	5	4	20
4.0 x 1000	5	4	20