



# TIGFIL 70S-A1

GTAW LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.28 **ER70S-A1**

### CLASSIFICATION:

EN ISO 21952-B

G 52 I1 1M3

IS 6419

SLA-1-I-501

### KEY FEATURES:

- Copper coated low alloy GMAW wire
- Typical 0.5Mo content
- Smooth feeding and stable arc under optimum welding conditions
- Increase strength at elevated temperature
- Weld deposit highly resistant to cold cracking
- Shiny welds of radiographic quality

**APPROVALS:** IBR/CE

### TYPICAL APPLICATIONS:

- Welding creep resistant 0.5% Mo steels and fine grained steels with service temperatures up to 500°C
- High temperature and high pressure boilers
- Suitable for 15Mo3, 16Mo3, 14Mo6
- Welding low alloy steels such as type ASTM A335 grade P1 and similar materials
- Pipe line and crane construction as well as in structural steel engineering



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

C	Mn	Si	Mo
0.08	1.1	0.55	0.45

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 620°C for 1 hr	580	470	24

### 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 and follow handling instructions mentioned on the box	All Positions  
2.0 x 1000	20		
2.4 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.