

TIG welding rod and wire for mild steel and 490 MPa high tensile strength steel

Classification: ASME / AWS A5.18 ER70S-2
JIS Z3316 YGT50

Features: •Suitable for root pass welding of pipes

Shielding Gas: Ar

Polarity: DC-EN

Chemical composition of rod and wire (%) as per AWS

	C	Si	Mn	P	S	Cu	Al	Ti	Zr
Example	0.04	0.54	1.25	0.007	0.014	0.25	0.07	0.08	0.04
Guaranty	≤0.07	0.40~ 0.70	0.90~ 1.40	≤0.025	≤0.030	≤0.50	0.05~ 0.15	0.05~ 0.15	0.02~ 0.12

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°C×h)
Example	560	620	28	-29°C: 200	AW
	520	600	30	-29°C: 160	625x8
Guaranty	≥400	≥480	≥22	-29°C≥27	AW

Packages

dia. (mm)	Type	Weight (kg)	Length (mm)	Weight per piece(g)
0.9	spool	10	-	-
1.2	tube	5	1,000	9
1.6	spool	20	-	-
	tube	5	1,000	16
2.0	tube	5	1,000	25
2.4	tube	5	1,000	35
3.2	tube	5	1,000	63