



AUTOMIG 70S-A1

GMAW LOW ALLOY STEEL (High Temperature)

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

CLASSIFICATION:

EN ISO 21952-B
G 52 M13 1M3

IS 6419
SLA-1-M-501

KEY FEATURES:

- Copper coated low alloy GMAW wire & rod
- 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, mm	Kg/Spool		
1.2	15	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
Ar/1-5O ₂	15-20