



TIGFIL 70S-2 SPL

GTAW C-Mn Steel

AWS A/SFA 5.18 **ER70S-2**

CLASSIFICATION:

EN ISO 636-A
W 42 5 2Ti

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

APPROVALS: ABS/BV/IBR/CE

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 up to 520 MPa

TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Ti	Zr	Al
0.05	1.1	0.5	0.1	0.06	0.1


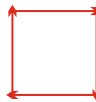
MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -46°C, J
Typical	As Welded	560	480	27	50

Hardness, 3 Layers: 210 BHN max

Special Test: HIC and SSCC (NACE)

PARAMETERS - PACKING DATA:

Ø x L, mm	Net Wt Kg/Box		
1.6 x 1000	20	 DCEN STORAGE / HANDLING : Keep dry during storage and handling	All Positions 
2.0 x 1000	20		
2.4 x 1000	20		
3.15 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.