



TIGFIL 70S-6

GTAW C-Mn Steel

AWS A/SFA 5.18 **ER70S-6**

CLASSIFICATION:

EN ISO 636-A
W 46 5 3Si1

KEY FEATURES:

- C-Mn steel filler rod
- Uniform copper coating
- Controllable weld pool
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Root pass pipe welding
- Thin sheet metal, Auto body
- Farm implements, Steel casings
- Collision repair, Pressure vessels
- Application in high pressure piping for shipbuilding, petro chemical and nuclear power plant



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si
0.075	1.45	0.85

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	As Welded	560	485	27	50

PARAMETERS - PACKING DATA:

Ø, 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		

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.