

MERIT™ JG-52 is copper coated TIG rod for welding of mild steels.

APPLICATION

- General construction
- Small diameter pipe and tubing
- Sheet metal applications
- Root pass pipe welding

KEY FEATURES

- High quality, high toughness welds
- Embossed on each end for easy alloy identification
- Produces X-ray quality welds over most surface conditions
- Manufactured under a quality system certified to ISO 9001 requirements

WELDING POSITIONS

All Position (With 100% Ar)

CONFORMANCE

AWS A5.18/A5.18M: ER70S-2

PACKAGING AND AVAILABLE DIAMETERS

Diameter (mm)	5kg/plastic tube × 1000mm	Product No.
1.6	5kg × 1000mm	CEJ70S2016055F2W01
2.0	5kg × 1000mm	CEJ70S2020055F2W01
2.4	5kg × 1000mm	CEJ70S2024055F2W01
3.2	5kg × 1000mm	CEJ70S2032055F2W01
4.0	5kg × 1000mm	CEJ70S2040055F2W01

CHEMICAL COMPOSITION – Solid Electrode

	C	Mn	Si	P	S
AWS Requirements (%)	0.07 Max.	0.90-1.40	0.40-0.70	0.025 Max.	0.035 Max.
Typical Values (%)	0.062	1.11	0.49	0.007	0.008

MECHANICAL PROPERTIES – All Weld Metal

	Yield Strength, Mpa	Tensile Strength, Mpa	Elongation (%)	Impact ISO -V, (J) -30°C
AWS Requirements Min.	400	480	22	27
Typical Values	450	545	29	120