

T-70S2

For mild steels and 490MPa tensile strength steel

Classifications

| | | | |
|---------------|----------------|------------|---------------|
| EN 636-A:2008 | : W 46 3 W2Ti | JIS Z 3316 | : W 49 A 3U 2 |
| EN 636-B:2008 | : W 49A 3 U W2 | KS D 7140 | : YGT50 |
| AWS A5.18-05 | : ER70S-2 | | |

Description

- For mild steel and 490MPa tensile strength steel welding of pipes, offshore drilling rigs and structural steels, etc.
- This rod is a multiple deoxidized rod containing small amounts of zirconium, titanium and aluminum in addition to the manganese and silicon deoxidizers characteristic of steel rod group.
- This rod producing superior quality welds with minimum porosity even over rust and mill scale.

Typical chemical composition of rod (%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.07 | 0.54 | 1.18 | 0.015 | 0.011 |

Typical mechanical properties of all-weld-metal

| | Y.S (MPa) | T.S (MPa) | El. (%) | IV (J) -30°C | Remarks |
|-----------|--------------|--------------|------------|-----------------|---------|
| AWS A5.18 | min. 400 | min. 480 | min. 22 | ≥ 27 | Ar |
| EN 636-B | min. 390 | 490-670 | min. 18 | ≥ 47 | Ar |
| Example | 490 | 570 | 29 | 180 | Ar |

Operating data

| | |
|----------------|-----------|
| Dia.(mm) | 2.4~3.2 |
| Current (Amp.) | 200 ~ 300 |

Polarity and Shielding gas

- DCEN (DC-)
- Ar : (15~25ℓ/min)