

**TIG welding rod and wire****Features:** ▪ Suitable for root pass welding of pipes**Classification:** AWS A5.18 ER70S-2**Shielding Gas:** Ar**Identification color:** 1st Blue white**Polarity:** DCEN**Packaging data**

φ mm	Spool		Tube		
	kg		kg	Length mm	g/piece
0.9	10	-	-	-	-
1.0	10	-	-	-	-
1.2	-	-	5	1,000	9
1.6	-	20	5	1,000	16
2.0	-	-	5	1,000	25
2.4	-	-	5	1,000	35
3.2	-	-	5	1,000	63
<b>Volume mm</b>	240W, 110H, 230L	280W, 110H, 270L	40W, 35H, 1015L		

**Composition (wire mass%)**

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.04	0.07
<b>Si</b>	0.54	0.40~0.70
<b>Mn</b>	1.25	0.90~1.40
<b>P</b>	0.007	0.025
<b>S</b>	0.014	0.035
<b>Ni</b>	0.04	0.15
<b>Cr</b>	0.05	0.15
<b>Mo</b>	0.01	0.15
<b>Cu</b>	0.16	0.50
<b>V</b>	<0.01	0.03
<b>Al</b>	0.07	0.05~0.15
<b>Ti</b>	0.08	0.05~0.15
<b>Zr</b>	0.05	0.02~0.12

Note: <sup>a</sup> Single values are maximum.**All-weld mechanical properties**

	Typical		Guaranty
<b>0.2%YS (MPa)</b>	560	520	400min.
<b>TS (MPa)</b>	620	600	483min.
<b>El on 4d (%)</b>	28	30	22min.
<b>IV -29°C (J)</b>	200	160	27min.
<b>PWHT (°C×h)</b>	AW	625x8	AW