



TIGFIL 70S-2

GTAW C-Mn Steel



TRIPLE DEOXIDIZED COPPER COATED C-Mn STEEL FILLER ROD

CLASSIFICATION : EN ISO 636-A	AWS A/SFA 5.18	APPROVALS :
W 42 3 WS2	ER 70S-2	ABS/DNV/LRA/NPCIL/IBR

KEY FEATURES :

- Triple deoxidized copper coated C-Mn steel filler rod
- High quality, high toughness welds
- Excellent choice for welding over rust and mill scale
- Radiographic quality weld

WELDING POSITION :	DCEN
Shielding Gas: Ar	Gas Flow Rate, LPM : 8-15

TYPICAL APPLICATIONS :

- Welding of Pressure vessel, Boilers involving unalloyed and micro-alloyed structural steels with specified UTS up to 520 MPa
- High quality pipe welding of mild and medium tensile steels
- Best suited for single side, melt through welding

STORAGE / HANDLING :

Keep dry during storage and handling

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Ti	Zr	Al	Cu*	S	P
Specification	0.07 max	0.90-1.40	0.40-0.70	0.05-0.15	0.02-0.12	0.05-0.15	0.50 max	0.030 max	0.025 max

* Including Cu in the coating

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Specification	As Welded	500 min	420 min	22 min	28 min

SPECIAL TEST :

Hot Tensile Test at 196°C

PACKING DATA :

Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
1.6 x 1000	5	4	20
2.0 x 1000	5	4	20
2.5 x 1000	5	4	20
3.2 x 1000	5	4	20
4.0 x 1000	5	4	20

