



# TIGFIL 70S-6

C-Mn STEEL SOLID FILLER ROD

GTAW C-Mn Steel



**CLASSIFICATION :** EN ISO 636-A      AWS A/SFA 5.18      CSA W48      **APPROVALS :**

W 42 5 W3Si1      ER 70S-6      B-G 49A 3 C1 S6      CWB

**KEY FEATURES :**

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

**WELDING POSITION :** **DCEN**

**Shielding Gas:** Ar      **Gas Flow Rate, LPM :** 8-15

**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

**STORAGE / HANDLING :**

Keep dry during storage and handling

**CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :**

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>	<b>Cu*</b>
Specification	0.06-0.14	1.40-1.60	0.80-1.0	0.025 max	0.025 max	0.50 max

\* Including Cu in the coating

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact at -50°C, J</b>
Specification	As Welded	500-640	420 min	22 min	27 min

**PACKING DATA :**

<b>Ø x L, mm</b>	<b>Primary Box, Kg</b>	<b>No. of Primary Boxes</b>	<b>Net Wt. of Carton, Kg</b>
1.6 x 1000	5	4	20
2.0 x 1000	5	4	20
2.5 x 1000	5	4	20

