

TIGFIL 70S-A1

Classification
AWSA/SFA 5. 28 : ER 70S-A1

Approvals :
TOYO ER 70S-A1

Identification: AWS classification embossed at one end of the wire.

Characteristics

A copper coated low alloy GTAW/TIG filler/rod with Mo around 0.5%. It is characterized by smooth flow and gives shiny welds of radiographic quality.

Typical Applications

For welding of Carbon-moly steels such as ASTM A-240 Gr. B, DIN steels, 15Mo3, etc.

Wire Chemistry, wt %

C	Mn	Si	S	P	Mo
0.08-0.12	0.90-1.30	0.30-0.70	0.020 max	0.020 max	0.40-0.60

Properties of weld metal with 100% Argon gas shielding **Current Condition: DC (-)**

All Weld Mechanical Properties As welded condition

UTS MPa	520 min	CVN Impact value J
Yield strength MPa	400 min	at - 20°C
Elongation % (L=4xd)	22 min	47 Min
The chemistry & mechanical properties of the weld metal will vary with the type of shielding gas used.		

Packing Data

Dia (mm)	1.6	2.0	2.5
Length (mm)	1000	1000	1000
Primary Tube (Kg)	5	5	5
No. of Tubes	4	4	4
Secondary Cartons (Kg)	20	20	20

TIGFIL Wires are sealed in polyethylene bags and then packed in primary tubes.

TIGFIL Wires are also available in 5 Kg PSLW spools in 0.8, 1.0 and 1.2 mm sizes for orbital GTAW/TIG welding.



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