

TIGFIL 70S2 (Special)

Classification
AWSA/SFA 5.18 : ER 70S-2

Approvals
SONCAP
TOYO ER 70S-2

Identification: Name embossed at both ends of the wire.

Characteristics

Triple deoxidized copper coated mild steel GTAW filler rod. having very low impurities. Sulphur and phosphorus in the wire as well as weld metal do not exceed 0.01%. Deposits weld metal that is strong, tough and ductile. It passes HIC and SSCC test as per GS-8 Annexure - I NACE specification. Gives radiographic quality welds.

Typical Applications

For welding NACE pipes - type A106 Gr B or equivalent, structurals, Pressure vessels and Boilers involving unalloyed and microalloyed structural steels with specified tensile strength upto 520 Mpa to meet subzero impact down to - 51°C.

Wire Chemistry, wt %

C	Mn	Si	S	P	Ti	Zr	Al
0.07 max	0.90-1.40	0.40-0.70	0.010 max	0.015 max	0.05-0.15	0.02-0.12	0.05-0.15

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

All Weld Mechanical Properties As welded condition

UTS MPa	480 min	CVN Impact value J
Yield strength MPa	400 min	at - 51°C
Elongation % (L=4xd)	22 min	28 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	3.2	4.0
Length (mm)	1000	1000	1000	1000	1000
Primary Tube (Kg)	5	5	5	5	5
No. of Tubes	4	4	4	4	4
Secondary Cartons (Kg)	20	20	20	20	20

Special Test :

Test Type	Remarks
HIC & Sulphide SCC (NACE)	Passed

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.

AUTOMIG 70S2 (Special), in spool form, available for GMAW process, on demand.



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