

# TIGFIL 70S2

## Classification

AWSA/SFA5.18 : ER 70S-2

## Approvals

DNV	3YMS	ABS	ER 70S2
LRA	ER 70S2	SONCAP	ER 70S2
TOYO	ER 70S2	NPCIL	
MND	ER 70S2		

**Identification:** Name embossed at both ends of the wire.

## Characteristics

Triple deoxidized copper coated mild steel GTAW/TIG filler/rod. Smooth flow, stable arc and minimum spatter under optimum welding conditions. Gives radiographic quality welds..

## Typical Applications

For welding of pressure vessels and boilers involving unalloyed and micro-alloyed structural steels with specified tensile strength upto 520 MPa / mm<sup>2</sup>.

## Wire Chemistry, wt %

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

**Current Condition:** DC (-)

## All Weld Mechanical Properties As welded condition

Shielding Gas	UTS	YS	Elongation	CVN Impact, value J
	MPa	MPa	%(L=4×d)	at - 30°C
100% Ar	480 min	400 min	22min	28 min

The chemistry and 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

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, in spool form, available for GMAW process, on demand.



WELDERS TO THE NATION SINCE 1951  
**ADOR WELDING LIMITED**

(Formerly Known as Advani-Oerlikon Ltd.)

[www.adorwelding.com](http://www.adorwelding.com)

