

❖ Product Description

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| <ul style="list-style-type: none"> I. The rod is made by triple deoxidised copper coating to provide extra protection to weld. II. Effective for welding over rust or mill scale III. The weld produced are of high quality and excellent toughness | <ul style="list-style-type: none"> IV. Highly recommended for TIG welding for almost all grades of steel V. The weld produced are applicable for Radiography VI. Gives minimum spatter when used under optimum welding conditions |
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❖ Range of Application

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| <ul style="list-style-type: none"> I. Can be used for welding various pressure vessel, boilers. II. Effectively used in variety of mild steel alloys III. Excellent performance on small diameter pipes and tubes | <ul style="list-style-type: none"> IV. Recommended in sheet metal work for TIG Welding for thin sheets V. Good welds produced on pipes made from mild and medium tensile steel |
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❖ Classification

- AWS/SFA 5.18 ER70S-2

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Ni	Cu	Cr	Mo	V	Ti	Zr	Al
ER70S-2	Min	-	0.90	-	0.40	-	-	-	-	-	-	0.05	0.02	0.05
	Max	0.07	1.40	0.035	0.70	0.025	0.15	0.50	0.15	0.15	0.03	0.15	0.12	0.15

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
As Welded	490	400	22	27J

❖ Wire Size & Weld Position

- Diameter in mm-1.6, 2.0, 2.40, 3.20, 4.00 and 5.00.
- All Position

❖ Current and Gas Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

- (1) All the value above mentioned are typical values

- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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