

TIG welding rod and wire

Features:	▪ Suitable for low temperature steel
Classification:	AWS A5.28 ER70S-G
Shielding gas:	Ar
Identification color:	1st Black
Polarity:	DCEN

Packaging data

φ mm	Spool		Tube	
	kg	kg	Length mm	g/piece
1.2	10	-	-	-
1.6	-	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	35
3.2	-	5	1,000	63
Volume mm	240W, 110H, 230L		40W, 35H, 1015L	

Composition (wire mass%)

	Typical	Guaranty ^a
C	0.05	0.09
Si	0.31	0.60
Mn	1.07	0.70~1.30
P	0.005	0.025
S	0.007	0.025
Ni	0.79	0.60~1.00
Mo	0.15	0.30
Cu	0.15	0.40

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	Wire	Rod
1.2	50~280	-
1.6	-	60~220
2.0	-	80~240
2.4	-	100~260
3.2	-	150~300

All-weld mechanical properties

	Typical		Guaranty
	460	390	
0.2%YS (MPa)	540	450	360min.
TS (MPa)	33	35	483min.
EI on 4d (%)	200	250	24min.
IV -60°C (J)	AW	620x1	27min.
PWHT (°C/h)			AW

Approvals

ABS	4YSA, MG
LR	MG
DNV	VYM, NV4-4L
BV	4YM, UP
NK	KSWL2G (I)
GL	4Y