

## TIG welding rod and wire

<b>Features:</b>	▪ Suitable for 3.5% Ni steel
<b>Classification:</b>	AWS A5.28 ER70S-G
<b>Shielding gas:</b>	Ar
<b>Identification color:</b>	1st Yellowish green
<b>Polarity:</b>	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
<b>Volume mm</b>	240W, 110H, 230L		40W, 35H, 1015L	

## Composition (wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.02	0.06
<b>Si</b>	0.34	0.60
<b>Mn</b>	0.86	0.60~1.10
<b>P</b>	0.004	0.020
<b>S</b>	0.008	0.020
<b>Ni</b>	3.53	3.20~3.90
<b>Mo</b>	0.15	0.30
<b>Cu</b>	0.17	0.35

Note: <sup>a</sup> 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
	<b>0.2%YS (MPa)</b>	510	490
<b>TS (MPa)</b>	580	570	483min.
<b>EI on 4d (%)</b>	30	31	24min.
<b>IV -101°C (J)</b>	69	78	-105°C: 27min.
<b>PWHT (°C×h)</b>	AW	620x1	AW & 620±15x1