

# GETIG 70S6



NACE GRADE F TIG FILLER WIRE

IDENTIFICATION : ER 70S - 6

CLASSIFICATION : AWS A-5.18 Class ER 70S-6

## DESCRIPTION :

Copper coated filler wire having deoxidants such as Mn and Si content. Smooth flow and gives shiny bead under optimum welding conditions. The deposited weld meet x-ray / radiographic quality code requirement.

## TYPICAL USES :

For welding of structural, pressure vessels and boilers involving and micro alloyed structural steel wuth specified tensile strength upto 520N/mm to meet sub zero Impact requirements down to 29°C.

Weld Metal Analysis (Range) % :

C	M	Si	S	Cu	P
0.06-0.15	1.4-1.85	0.8-1.15	0.025 max	0.50 max	0.030 max

## MECHANICAL PROPERTIES (RANGE) :

Tensile Strength N/mm <sup>2</sup> (Mpa)	Yield Stress N/mm <sup>2</sup> (Mpa)	Elongation (%) (L=4D)	Charpy V-notch impact strength in joules	
500-620	400-510	24-30	-30°C	50-120

**SHIELDING GAS:** 100% welding grade CO2 or 80 % Argon + 20 % CO2

PACKING DATA :

SIZE (mm)	LENGTH (mm)	Qty Per Packet in Kgs	Qty Per Box in Kg
1.6	1000	5 Kg	5 x 4 = 20 Kg.
2.00	1000	5 Kg	5 x 4 = 20 Kg.
2.40/2.50	1000	5 Kg	5 x 4 = 20 Kg.
3.15/3.20	1000	5 Kg	5 x 4 = 20 Kg.