

TIG filler metal designed for welding non-alloy steels. It is recommended for bottom passes where controlled penetration is required, and is suitable for tank and pipeline applications.

Classification

AWS 5.18 : ER70S-6
 EN 636A / EN ISO 14341A : G/W3Si1
 DIN 8559 : WSG2

Applications

- In piping,
- For penetration passes.

Product benefits

- High-quality assembly of structural steels.
- Excellent mechanical qualities, particularly for TIG welding on low thicknesses

Chemical properties

C %	Si %	Mn %
0.08	0.85	1.45

Mechanical properties

Re	Rm	A 5 d	KV 20°C	KV 0°C
> 420 Mpa	500-640 Mpa	> 22%	150 J	100 J

Recommendations

Ø electrode (mm)	1,6	2	2,4
thickness (mm)	1,5 ▶ 2	2,0 ▶ 2,5	2,5 ▶ 3,0
welding current (A)	60 ▶ 95	90 ▶ 110	120 ▶ 150

Gas protection in accordance with EN ISO 14175
 100% Argon (I1)



Packaging

Réf.	Ø (mm)	length (mm)	
087224	Ø 1.6	330	60
087231	Ø 2.0	330	40

Réf.	Ø (mm)	length (mm)	
087019	Ø 1.6	1000	315
087217	Ø 2.0	1000	205
087033	Ø 2.4	1000	142