

Classification

AWS A5.18

EN ISO 636-B

ER70S-2

W 49A 3 2

Characteristics and typical fields of application

BOHLER S ER70S-2 is a copper coated GTAW rod containing Al, Ti and Zr as strong deoxidants in addition to Mn and Si and is often referred to as triple deoxidised.

This has advantages when rimming or semi-killed mild steels are welded or where joint operations are rusty or contaminated.

Base Materials

Especially for root pass welding of steels up to a yield strength of 420 MPa (60 ksi)

S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S420N, S275M-S420M, P235GH-P355GH, P355N, P285NH-P355NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L245MB-L415MB, GE200-GE240

ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. A, C, E; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60

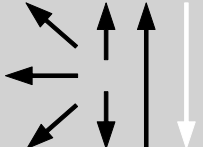
Typical analysis of solid wire (wt.-%)

C	Si	Mn	Ti	Zr	Al
0.05	0.5	1.2	+	+	+

Mechanical properties of all-weld metal

Heat treatment	Yield strength R_e N/mm ²	Tensile strength R_m N/mm ²	Elongation ($L_0=4d_0$)	Impact work ISO-V KV J	
	MPa	MPa	%	+20°C	-30°C
As Welded	420	520	24	80	47

Operating data

	Polarity DCEN	Shielding Gas : Argon
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Approval

ABS, CE

Size and Packaging

Size mm	Kg / Plastic tube
1.60	5.0
2.00	5.0
2.40	5.0
3.20	5.0