



## SELECTARC TIG F55

Old reference : TIG GALVARC

### Classification

AWS A5.18 : ER70S-2

### Characteristics

GTAW- copper coated wire electrodes to weld low alloyed standard construction / boiler steels. Especially for galvanized and Zinc coated steels used for general metal constructions, in the automobile industry, blacksmithing etc.

### Typical Weld Metal Composition (%)

C	Si	Mn	Al	Ti	Cu	Zr	S	P	Fe
0.06	0.60	1.20	0.10	0.10	0.20	0.08	0.01	0.015	base

### All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impact (KV)	
	R <sub>m</sub> (MP <sub>a</sub> )	R <sub>e</sub> (MP <sub>a</sub> )		Temp. °C	J
AW	560	460	28	- 30	100

### Welding Current & Instructions

Welding Mode	Shielding Gas
TIG = -	Ar : 6 - 12 l/min Back shielding : N <sub>2</sub> / H <sub>2</sub> : 3 - 6 l/min

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