



TIG F56

Old reference: TIG 70S3

Classification

AWS A5.18 : ER70S-3
 ISO 636-A : W2Si

Material N° : 1.5112

Description & Applications

GTAW rods to weld low alloyed standard construction / boiler steels like S235 to S355 and P235 to P310.

Main applications: For general metal constructions, in the automobile industry, blacksmithing, ship building etc. Advise in piping systems, for root passes and high quality assemblies...

Typical Chemical Composition (%)

C	Si	Mn	Cu	P	S	Fe
0.07	0.65	1.1	0.2	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
460	560	26	+20°C	150
			-20°C	90
			-50°C	50

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Nitrogen / H ₂ : 3-6 l/min

ind.12



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