



TIG F57

Old reference: TIG 70S6

Classification

AWS A5.18 : ER70S-6
ISO 636-A : W3Si1

Material N° : 1.5125

Description & Applications

GTAW rods to weld low alloyed standard construction / boiler steels like S235-S355, P235-P355, S255N-S420N.

Main applications: For general metal constructions, in the automobile industry, blacksmithing, ship building etc.

Base material:

Construction steels for general use , Tube steels, Ship steels

EN- Designation	S185 – S355 P235 – P355	L210 – L360
Ship steels	Quality A and B	
ASTM	A285 grade C A442 grade 55, 60	A414 grade C, D, E, F A515 grade 55, 60, 65

Typical Chemical Composition (%)

C	Si	Mn	P	S	Fe
0.07	0.85	1.45	<0.02	<0.015	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
470	560	26	+20°C	120
			-20°C	90
			-40°C	60

Welding Current & Instructions

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

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