

T - 50

CLASSIFICATION

EN ISO 636-A	AWS / ASME SFA-5.18
W 46 3 W3Si1	ER70S-6

DESCRIPTION AND APPLICATION

Rod for GTAW of mild and low-alloy steels with tensile strength up to 490 N/mm². Weld metal has excellent mechanical and toughness properties in low temperature conditions. Rod is generally used in root pass welding of pipes in all positions. Proper tungsten electrode extension from the tip of torch is 4 to 6 mm in general.

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R _{eL} N/mm ²	R _m N/mm ²	A ₅ %	KV (-30°C) J
> 490	580	30	130

APPROXIMATE CHEMICAL COMPOSITION OF THE ROD

	C	Si	Mn	P	S
%	0,07	0,82	1,52	≤ 0,012	≤ 0,015

SHIELDING GAS

I1 (Ar)

PACKAGING

Rod diameter mm	Weight of packaging kg
2,4; 3,2	5

APPROVALS

ABS (2YSA); LR (YM15)

