

PRODUCT DATA SHEET

TIG S2



TIG S2 is suitable to weld mild and carbon steels. TIG S2 is generally used in root pass and to support the welding when no back pass is possible. Excellent mechanical and toughness properties when in low temperature conditions.

Classifications

AWS	A5.5	ER 70S-2
EN	I 668	W464W2Ti

Typical Chemical Analysis (All weld metal)

% Carbon	0,06	% Titanium	0,01
% Manganese	1,20	% Zirconium	0,09
% Silicon	0,50	% Aluminium	0,10
% Sulphur	0,012	% Copper	0,15
% Phosphorous	0,012		

Typical Mechanical Properties (All weld metal)

Yield Strength	600 MPa
Tensile Strength	490 MPa
% Elongation	28
Charpy V-Notch at +20°C	200 J
Charpy V-Notch at -20°C	120 J
Charpy V-Notch at -30°C	100 J
Charpy V-Notch at -40°C	70 J

Packing Data TIG (DC-)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,6	100	12	5,0	W078030
2,4	100	12	5,0	W078032

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