

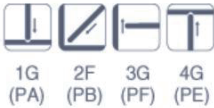
ER70S-2

AWS A5.18 ER70S-2

Description:

ER70S-2 is a premium wire for welding on all grades of mild and carbon steels, producing quality welds with minimal porosity. It is a triple deoxidized wire (Zirconium, Titanium, and Aluminum) making it an excellent choice for welding over rust and mill scale. Used for carbon steels and alloy steels with 500MPa tensile strength structures welding, and high speed welding of sheet plates and pipelines.

Welding Position:



Diameters:

0.8mm, 0.9mm, 1.0mm, 1.2mm, 1.4mm, 1.6mm.

Typical Mechanical Properties:

Tensile strength(MPa):	520
Yield strength(MPa):	440
Elongation(%):	29
Impact values(≥ 27)/(-20°C):	52

Typical Chemical Compositon:

C	Mn	P	S	Si	Ti	Al	Zr	Cu	V
0.08	1.32	0.010	0.008	0.68	0.10	0.09	0.11	-	-

Welding Current:

Diameter(mm)	0,8	1,0	1,2	1,6
Current/A	F/H 50-200	80-250	100-360	170-390
Current/A	V/OH 50-140	80-160	80-220	--

Note:

1. Insensitive to impurities (water, oil, rust, etc) on weld piece
2. 2, Shield gas: 80%Ar + 20% CO₂.
3. Gas speed: 15-25L/Min
4. **Tig rods ER70S-2 1.6mm, 2.0mm, 2.4mm, 3.2mm available**