

TG 1

TIG Welding Wire - Non Alloyed Steels

Standards	
AWS/ASME SFA - 5.18	ER70S-3
EN ISO 636 - A	W 42 3 2Si
TS EN ISO 636 - A	W 42 3 2Si
DIN M. No.	1.5112

Properties and Applications

GTA (TIG) welding rod for unalloyed steels, fine grained steels and pipes. Particularly suitable for welding of galvanized and pre-painted steels, welding low alloy steels in pipe-lines, boilers and tank production. Used in root and cap passes in chemical, petrochemical, water, natural gas pipes joints safely. Suitable also welding in thin metal plates and repair welds. Characterized by a reduced slag formation and smooth welding deposit. Thin and homogeneous copper coating increase resistance to rusting.

Materials	
Width	DIN
S185 - P275T1	St 33.0 - St 44.0
P235GH, P265GH	H I, HII
P235G1TH - P255G1TH	St 35.8 - St 45.8
	A, B, D, E

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn
Welding Wire	0.05	0.60	1.30

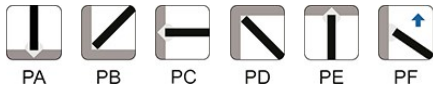
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	I1	440	530	29	-30°C → 100

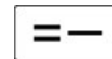
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
1.60x1000
2.00x1000
2.40x1000
3.20x1000
4.00x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
21101GBKM2	1.60x1000	5 kg	5.30	4	21.40	Cardboard Tube
21101HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
21101IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube
21101LBKM2	3.20x1000	5 kg	5.30	4	21.40	Cardboard Tube
21101MBKM2	4.00x1000	5 kg	5.30	4	21.40	Cardboard Tube

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.