

T-70S2

For mild steels and 490MPa tensile strength steel

Classifications

EN ISO 636-A:2017	: W 46 3 2Ti	KS D 7140:2005	: YGT50
EN ISO 636-B:2017	: W 49A 3U 2	JIS Z 3316:2011	: W 49 A 3U 2
AWS A5.18:2005	: ER70S-2		

Description

- For mild steel and 490MPa tensile strength steel welding of pipes, offshore drilling rigs and structural steels
- This rod is a multiple deoxidized rod containing small amount of zirconium, titanium and aluminium in addition to the manganese and silicon deoxidizers characteristic of steel rod group.
- The rod producing superior quality welds with minimum porosity even over rust and mill scale.



Typical chemical composition of rod (%)

C	Si	Mn	P	S
0.07	0.54	1.18	0.015	0.011

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J) -30 °C	Remarks
AWS A5.18	Min. 400	Min. 480	Min. 22	≥ 27	Ar
EN 636-B	Min. 390	490-670	Min. 18	≥ 47	Ar
Example	490	570	29	180	Ar

Welding positions

Dia. (mm)	2.4 – 3.2
Current (Amp.)	200 - 300

Polarity & shielding gas

- DCEN (DC-)
- Ar: 100% Ar (15 – 25 l/min)

Approvals

ABS	DNVGL
3Y	III YM