

GETIG 70S6

NACE GRADE TIG FILLER WIRE

IDENTIFICATION

Getig 70S6, ER 70S6

CLASSIFICATION

AWS A-5.18 Class ER 70S6

DESCRIPTION

Copper coated filler wire having deoxidants such as Mn and Si content. Smooth flow and gives shiny bead under optimum welding conditions. The deposited weld meet x-ray / radiographic quality code requirement.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	Cu	P
0.06 - 0.15	1.4 - 1.85	0.8 - 1.15	0.025 max	0.50 max	0.030 max

MECHANICAL PROPERTIES (RANGE)

TS (N/mm ²) (MPa)	YS (N/mm ²) (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
500 - 620	400 - 510	24 - 30	-30°C	50 - 120

TYPICAL APPLICATIONS

- For welding of structural, pressure vessels and boilers involving and micro alloyed structural steel with specified tensile strength upto 520 N/mm to meet sub zero
- Impact requirements down to 29°C.

SHIELDING GAS : 100% welding grade CO₂ or 80 % Argon + 20 % CO₂

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20