

# GM 70S2

## IDENTIFICATION

GM 70S2, ER 70S2

## CLASSIFICATION

AWS A-5.18: ER 70S-2

## DESCRIPTION

Copper coated filler wire has Al, Ti and Zr as strong deoxidants with Mn and Si content. The wire has very low impurities such as S, P etc and is suitable for applications involving subzero temperatures up to -30°C. This has advantages of semi-killed steels or rusty and contaminated joint area. 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	Zr	Al	Ti	S	P
0.07 max	0.9 - 1.4	0.40 - 0.70	0.02 - 0.12	0.05 - 0.15	0.05 - 0.15	0.020 max	0.025 max

## MECHANICAL PROPERTIES (RANGE)

TS (N/mm <sup>2</sup> )	YS (N/mm <sup>2</sup> )	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
510 - 620	410 - 550	22 - 28	-30°C	30 - 90

## TYPICAL APPLICATIONS

- For welding of structural, pressure vessels and boilers involving unalloyed and micro alloyed structural steel with specified tensile strength upto 550N/mm to meet sub zero Impact requirements down to -30°C.
- ASTM A 36, A106 A/B/C, A139 etc
- A516 Grade 70 etc.

**SHIELDING GAS :** Argon + 1 -2% Oxygen or (Argon + 2 -5% CO<sub>2</sub>)

## PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5 / 15.0
1	12.5 / 15.0
1.2	12.5 / 15.0
1.6	12.5 / 15.0