

ROYAL – Tig – T2 (ER 70S-2)

AWS A/ SFA 5.18 Class ER 70S-2

Applications

Structural pressure vessels and boiler involving unalloyed and micro alloyed structural steel with specific tensile strength upto 520 N/M2 to meet sub zero impact requirements at minus 51°C

Characteristics on Usage

Triple deoxidized mild steel wire smooth flow, stable arc and minimum spatter under optimum welding conditions. Gives radiography quality welds

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Zr%
0.07 Max	0.90 – 1.40	0.40 – 0.70	0.035- Max	0.025 Max	0.15 Max	0.15 Max	0.02-

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
480	400	22	27

Packing and Welding Current

SIZE (mm)	KG PER PACKET
1.20 x 1000	5
1.60 x 1000	5
2.00 x 1000	5
2.50 x 1000	5