


CATEGORY	GTAW Solid wires											
TYPE	Special TIG rod with de-oxidation additions for improved welding properties											
APPLICATIONS	recommended for applications that require high purity of the weld metal. Ideal for diluted, rusty, painted or galvanized steel plates in maintenance and repair. Car restoration, body shops, frames and overhaul work											
PROPERTIES	excellent desoxidation properties due to the addition of Zr, Ti and Aluminium.											
CLASSIFICATION	AWS EN ISO	A 5.18: ER 70S-2 636-A: W 46 2 2Ti										
SUITABLE FOR	S185-E360, S235JR-S355JR, S235J0-S450J0, S235J2-S355J2, S275N-S460N, S275M-S460M, S460Q, P235GH-P355GH, P275N-P460N, P355M-P460M, P355Q-P460Q ASTM: A27, A36, A106 grades A/B/C, A139, A210 grades A1/C, A214, A216 grades WCA/WCB/WCC, A234 grade WPB. A334 grade 1 / API: 5L grades X42-X65											
APPROVALS	CE											
WELDING POSITIONS:												
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)												
C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu	Al	Ti+Zr	
0.05	0.5	1.2	0.01	0.01	0.034	0.018	0.006	0.002	0.11	0.1	0.17	
ALL WELD MECHANICAL PROPERTIES												
Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)				RT	Impact Energy (J) ISO-V				
As Welded /	470	560	24				100	-30°C 55				
WELDING PARAMETERS / PACKING												
REDRYING TEMPERATURE	Not required											
GAS ACCORDING EN 14175	I1											