

CLASSIFICATIONS

EN ISO 14341-A : G2Si
 EN ISO 636-A : W2Si
 AWS A5.18 : ER 70 S-3

DESCRIPTION

- Welding of thin walled parts
- Root pass welding
- For making galvanized coating
- TIG welding of tubes and pipes
- Shielding gases: TIG: Ar / MAG: 20% CO₂, - 80% Ar or pure CO₂

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.10 | Si: 0.6 | Mn: 1.2

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-30°C)	Elongation (L _o =5d _o) (%)
min. 400	480 - 600	min. 47 J	min. 22

BASE MATERIALS

- S235J2G3-S355J2G3, P235T2-P355T2, L210NB - L290NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH P355GH, S235JR51-S235J4S, S315G1S-S355G3S, P255NH-P355NH, GE200-GE300

WELDING POSITIONS



CURRENT CONDITION

TIG D.C.(-) / MAG D.C.(+)

OPERATING DATA

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				
2010100016	2010100020	0.8	0.030"	15	BS/D/300
2010100017	2010100021	1.0	0.040"	15	D 100
2010100018	2010100022	1.2	0.047"	15	ECO PACK
2010100019	2010100023	1.6	0.062"	15	DRUM PACK
		(0.6,0.9,1.34,1.4)		(1.5,15,18,50,250,400)	
	2010200001	1,60 x 1000	1/16 x 39"	5	
	2010200002	2,00 x 1000	5/64 x 39"	5	
	2010200003	2,40 x 1000	3/32 x 39"	5	Carton
	2010200004	3,20 x 1000	1/8 x 39"	5	Box
	2010200005	4,00 x 1000	5/32 x 39"	5	
	2010200006	5,00 x 1000	3/16 x 39"	5	