

Classifications

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|---------------|----------------|------------|---------------|
| EN 636-A:2008 | : W 46 3 W3Si1 | JIS Z 3316 | : W 49 A 3U 6 |
| EN 636-B:2008 | : W 49A 3 U W6 | KS D 7140 | : YGT50 |
| AWS A5.18-05 | : ER70S-6 | | |

Description

- For mild steel and 490MPa tensile strength steel welding of structural steels, machineries and vehicles.
- Excellent mechanical and toughness properties in low temperature conditions.
- It is generally used in root pass welding of pipes in all positions.
- Proper tungsten electrode extension from the tip of torch is 4-6mm in general.

Typical chemical composition of rod (%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.07 | 0.82 | 1.52 | 0.012 | 0.015 |

Typical mechanical properties of all-weld-metal

| | Y.S (MPa) | T.S (MPa) | El. (%) | IV (J) -30°C | Remarks |
|-----------|--------------|--------------|------------|-----------------|---------|
| AWS A5.18 | min. 400 | min. 480 | min. 22 | ≥ 27 | Ar |
| EN 636-A | min. 460 | 530~680 | min. 20 | ≥ 47 | Ar |
| Example | 490 | 580 | 30 | 130 | Ar |

Operating data

| | |
|----------------|-----------|
| Dia.(mm) | 2.4~3.2 |
| Current (Amp.) | 200 ~ 300 |

Polarity and Shielding gas

- DCEN (DC-)
- Ar : (15~25ℓ/min)

Approvals

| Shielding gas | ABS | LR | KR |
|---------------|------|--------|--------|
| Ar | 2YSA | 4YMH15 | RSW54G |