

# T-70S2

For mild steels and 490MPa tensile strength steel

## Classifications

EN 636-A:2008	: W 46 3 W2Ti	JIS Z 3316	: W 49 A 3U 2
EN 636-B:2008	: W 49A 3 U W2	KS D 7140	: YGT50
AWS A5.18-05	: ER70S-2		

## Description

- For mild steel and 490MPa tensile strength steel welding of pipes, offshore drilling rigs and structural steels, etc.
- This rod is a multiple deoxidized rod containing small amounts of zirconium, titanium and aluminum in addition to the manganese and silicon deoxidizers characteristic of steel rod group.
- This rod producing superior quality welds with minimum porosity even over rust and mill scale.

## Typical chemical composition of rod (%)

C	Si	Mn	P	S
0.07	0.54	1.18	0.015	0.011

## 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-B	min. 390	490-670	min. 18	≥ 47	Ar
Example	490	570	29	180	Ar

## Operating data

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

## Polarity and Shielding gas

- DCEN (DC-)
- Ar : (15~25ℓ/min)