

## TG 2

TIG Welding Wire - Non Alloyed Steels

Standards	
AWS/ASME SFA - 5.18	ER70S-6
EN ISO 636 - A	W 46 2 3Si1
TS EN ISO 636 - A	W 46 2 3Si1
DIN M. No.	1.5125

### Properties and Applications

GTA (TIG) welding rod for unalloyed steels, fine grained steels and pipes. Particularly used in root and cap passes in chemical, petrochemical, water, natural gas pipes joints safely. Suitable also welding of thin metal plates, tanks, boilers and repair welds of them. Thin and homogeneous copper coating increase resistance to rusting.

Approvals & Certificates		
TUV DB	CE CWB	BV DNV-GL
Materials		
Width	DIN	
S185 - P355T1	St 33.0 - St 52.0	
S235J2 - S355J0	St 37.3 - St 52.3	
P235TR2 - P2355T2	St 37.4 - St 52.4	
P235G1TH - P255G1TH	St 35.8 - St 45.8	
E295	St 50.2	
P235GH - P265GH	H I - H II	
P295GH, P355GH	17Mn4, 19Mn5	
L210 - L360NB	StE 210.7 - StE 360.7	
GE 200, GE 240, GE 260	GS 38, GS 45, GS 52	
S255N - S380N	StE 255 - StE 380	
	A, B, D, E	
	X42, X46	

### Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn
Welding Wire	0.06	0.80	1.45

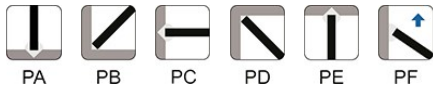
### Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	I1	480	560	28	-20°C → 95	-30°C → 80

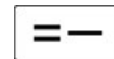
\* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

### Application Information

#### Welding Positions



#### Polarity:



Protection Gas:

I1

#### Welding Parameters & Efficiency

Diameter x Length (mm)
1.60x1000
2.00x1000
2.40x1000
3.20x1000
4.00x1000

### Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
21102GBKM2	1.60x1000	5 kg	5.30	4	21.40	Cardboard Tube
21102GGKM2	1.60x1000	5 kg	5.30	4	21.40	Plastic Box
21102HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
21102HGKM2	2.00x1000	5 kg	5.30	4	21.40	Plastic Box
21102IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube

21102IGKM2	2.40x1000	5 kg	5.30	4	21.40	Plastic Box
21102LBKM2	3.20x1000	5 kg	5.30	4	21.40	Cardboard Tube
21102LGKM2	3.20x1000	5 kg	5.30	4	21.40	PLASTIK
21102MBKM2	4.00x1000	5 kg	5.30	4	21.40	Cardboard Tube

**Storage & Re-Drying Information**

Shouldn't be exposed to high statical load and impact.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.