



M-90 ER70S-G **TIG ROD**

FEATURES

- *GOOD PERFORMANCE
- *HIGH DEPOSITION
- *GOOD BEAD APPEARANCE

APPLICATION

PIPES, SHIPBUILDING, AUTOMOTIVE, MACHINERY

CLASSIFICATION

*AWS/A5.18/ ASME SFA5.18
ER70S-G

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.07	0.83	1.43					

MECHANICAL PROPERTIES

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2)	N/mm2 (lbs/in 2)	(%)	oC (oF)	J (ft lbs)
460 (66,700)	530 (76,900)	27	-20 (-4)	36(27)

WELDING PARAMETERS

DIAMETER (mm)	1.6	2.4
LENGTH (mm)	1000	1000
CURRENT (amps)		

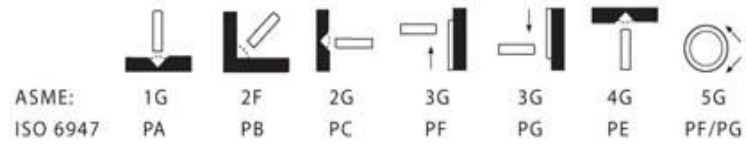
CURRENT

DC -

GAS

Ar

WELDING POSITIONS



Current

