



TIG F55

Old reference: TIG 70S2

Classification

AWS A5.18 : ER70S-2

ISO 636-A : W 46 4 2Ti

Description & Applications

Copper coated TIG rod to weld Carbon and Carbon-Manganese steels with tensile strength up to 510MPa. Also used for welding galvanised or electro-galvanised plates. Excellent mechanical and toughness properties at low temperature down to -40°C.

Main applications: For root pass in piping system and to support the welding when no back pass is possible.

Base material:

Construction steels for general use:

EN	ASTM
S275 – S355	A106 grade A, B, C
P275 – P355	A131 grade A, B, D
L210 – L360	A139

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti	Zr	V	P	S
Min	0.04	0.40	0.90					0.05	0.05	0.05			
Max	0.07	0.70	1.40	0.15	0.15	0.15	0.35	0.20	0.15	0.12	0.03	0.025	0.025
Type	0.06	0.60	1.2	0.04	0.03	0.01	0.20	0.10	0.10	0.08	0.01	0.015	0.01

All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	460	530	22	-40°C >47
Max		680		
Type	490	600	28	-20°C 120 -40°C 70

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175: I1 (Ar) 6-12 l/min Back shielding : I1 (Ar) / N1 (Nitrogen) 3-6 l/min

FT En-TA01-190219

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