



# TIG F56

Old reference: Carbotig

## Classification

AWS A5.18 : ER70S-3

ISO 636-A : W 42 3 2Si

## Description & Applications

Copper coated TIG rod to weld Carbon and Carbon-Manganese steels. Especially used for galvanized plates or pre-painted plates. Nice aspect of weld bead.

**Main applications:** Piping systems, tanks, boilers, general metal constructions...

**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	0.06	0.50	0.90									
Max	0.14	0.75	1.30	0.15	0.15	0.15	0.35	0.02	0.15	0.03	0.025	0.025
Type	0.08	0.55	1.2	0.04	0.04	0.01	0.10	0.005	0.01	0.005	0.02	0.02

## All Weld Metal Mechanical Properties

	R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	420	500	22	-30°C
Max		640		>47
Type	460	530	28	-20°C -30°C
				90 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-TA02-190219

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