



TIG F57HP

Classification

AWS A5.18 : ER70S-6

ISO 636-A : W 46 4 3Si1

Description & Applications

Copper coated TIG rod to weld low alloyed standard construction / boiler steels like S235-S355, P235-P355 and S255N-S420N.

Main applications: Used in piping for root pass for root pass for high quality level of welding with specific control.

Base material:

Construction steels for general use, Tube steels, Ship steels:

EN	Ship steels	ASTM
S185 – S355	Quality A and B	A285 grade C
P235 – P355		A442 grade 55, 60
L210 – L360		A414 grade C, D, E, F
		A515 grade 55, 60, 65

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti+Zr	V	P	S
Min	0.06	0.80	1.40									
Max	0.14	1.00	1.60	0.15	0.15	0.15	0.35	0.02	0.15	0.03	0.025	0.025
Type	0.08	0.80	1.45	0.04	0.04	0.005	0.15	0.01	0.004	0.001	0.015	0.012

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	480	580	28	+20°C	160
				-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-TA06-190219

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