



TIG F61

Old reference: TIG 70SA1

Classification

AWS A5.28 : ER70S-A1
ISO 21952-A : W MoSi

ISO 636-A : W2Mo

Description & Applications

Copper coated solid rod for GTAW of creep resisting steels alloyed with Molybden (0.5% Mo) used at temperatures up to 500°C. Excellent toughness values at low temperature down to -20°C.

Main applications: For piping systems, boilers, pressure vessels...

Base material:

Construction steels, Creep resisting steels :

EN	ASTM
16Mo3	A161/A209/A250 gr T1, A335 gr P1
P355GH	A537 Cl1, A414 gr G, A612
S420N – S460N	A572 grade 65, A633 gr E
S500N	A225 grade C, A517 gr
P460N	A225 grade C
S420NL - S500NL	A633 gr E, A225 gr C, A517 gr
P420NH - P500NH	A633 gr E, A225 gr C, A517 gr

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	Al	Ti+Zr	V	P	S
Min	0.08	0.50	0.90			0.40							
Max	0.12	0.70	1.30	0.15	0.15	0.60	0.30	0.01	0.02	0.15	0.03	0.020	0.020
Type	0.09	0.60	1.1	0.09	0.05	0.50	0.15	0.001	0.003	0.001	0.003	0.010	0.010

All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	400	515	22	+20°C
Max				47
Type	490	580	24	-20°C
				130

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-TF02-190219

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