



# TIG F57BP

## Classification

AWS A5.18 : ER70S-6

ISO 636-A : W 42 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 <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )	
Min	420	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-TA13-190219

**Liability:** This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.