



TIG F56HP

Classification

AWS A5.18 : ER70S-3

ISO 636-A : W 42 2 2Si

Description & Applications

Copper coated TIG rod to weld low alloyed standard construction / boiler steels like S235 to S355 and P235 to P355. Excellent mechanical and toughness properties at low temperature down to -30°C.

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

Base material:

Construction steels for general use:

EN	ASTM
S235 – S355	A106 grade A, B, C
P235 – 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	0.07	0.60	1.1	0.04	0.04	0.01	0.15	0.001	0.002	0.001	0.02	0.02

All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
Min	420	500	22	-20°C	>47
Max		640			
Type	460	560	28	+20°C	140
				-20°C	90
				-30°C	60

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-TA03-190219

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