

Standards :

TS EN ISO 14341-A	:	G2Ti
TS EN ISO 636-A	:	W2Ti
EN ISO 14341-A	:	G2Ti
EN ISO 636-A	:	W2Ti
AWS A5.18	:	ER 70 S-2

**Chemical Composition of Welding Wire-
% (Typical) :**

C	Mn	Si	Zr	Ti	Al
0.05	1.1	0.55	0.07	0.12	0.11

Mechanical Properties (MAG) :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-30°C)	Elongation (L ₀ =5d ₀)(%)
min. 400	min. 480	min. 47 J	min. 22

Typical Base Material Grades :

* S235J2G3-S355J2G3, P235T2-P355T2, L210NB-L290NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, S235JRS1-S235J4S, S315G1S-S355G3S, P255NH-P355NH, S255N-S420N, GE200-GE300,

Features and Applications :

- * Wire for welding mild and low alloy steels as well as thin walled materials.
- * Being triple deoxidized with Aluminium, Titanium and Zirconium as well as Manganese and Silicon, the wire is capable of producing efficient welds when the steel to be welded is rusty, dirty, undercoat painted.
- * It is recommended for pipe welding and for root passes in heavy vessel construction.
- * Also for welding of steels of which surface will be coated (such as galvanized, etc.)
- * Shielding gases : TIG: Ar MAG: 20% CO₂ - 80% Ar or pure CO₂

Welding Positions :



Current Type :

- TIG D.C.(-)
MAG D.C.(+)

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Weight Kg	Package Type
1.6 x 1000	1/16 x 39"	5	Carton Box
2.0 x 1000	5/64 x 39"	5	
2.4 x 1000	3/32 x 39"	5	
3.2 x 1000	1/8 x 39"	5	
4.0 x 1000	5/32 x 39"	5	
(0.8, 0.9, 1.0, 1.2, 1.4, 1.6)	(0.8, 0.9, 1.0, 1.2, 1.4, 1.6)	(1, 5, 15, 18, 50, 250, 400)	
0.8	0.030"	15	
1.0	0.040"	15	
1.2	0.047"	15	
1.6	0.062"	15	

Approvals :

SG 70 S2 : TSE, CE, GOST-R, SEPPO