

Signed by Mats Linde	Approved by Per Sundberg/Barbro Karlström	Reg no EN003255	Cancelling EN003178	Reg date 2006-03-01	Page 1 (2)
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REASON FOR ISSUE

Classification and mechanical properties modified.

GENERAL

A triple deoxidised copper coated mild steel rod particularly suited for TIG root runs in pipes. It can also be used without a flux for oxy-acetylene welding. Melting point is 1450 °C.

Shielding Gas: I1, I2, I3 (EN 439)

Alloy Type: Carbon-manganese steel (Mn/Si-alloyed)

CLASSIFICATIONS Weld Metal

EN 1668 W 46 4 W2Ti

CLASSIFICATIONS Wire Electrode

EN 1668 W2Ti
SFA/AWS A5.18 ER70S-2

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Ar			
C	0.05	0.04	0.07
Si	0.72	0.40	0.70
Mn	1.11	0.90	1.40
P	0.013		0.025
S	0.012		0.025
Cr			0.15
Ni			0.15
Mo			0.15
V			0.03
Cu			0.35
Al		0.05	0.15
Ti		0.05	0.15
Zr		0.02	0.12
Ti+Zr		0.07	0.25

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MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			Ar (I1) AWS
	Ar (I1) EN			
	As welded			
	Min	Max	Typ	Min
Rp0.2 (MPa)	460		570	400
Rm (MPa)	530	680	625	480
A4 (%)				22
A5 (%)	20		26	
Charpy V at -29°C (J)				27
Charpy V at -40°C (J)	47		180	