

# RASI TIG ER 70S-2

MADE IN INDIA

TIG / FILLER WIRE :- AWS ER 70S-2

## CHARACTERISTICS

RASI TIG ER 70S-2 is a Triple deoxidized mild steel wire smooth flow, stable arc and minimum spatter under optimum welding conditions.  
Gives radiography quality welds

## CLASSIFICATIONS

AWS A/ SFA 5.18 Class ER 70S-2

## TYPICAL APPLICATIONS

Structural pressure vessels and boiler involving unalloyed and micro alloyed structural steel with specific tensile strength upto 520 N/M2 to meet sub zero impact requirements at minus 51°C

## WELDING POSITIONS

ALL

## SHIELDING GAS

100% Argon.  
Current Condition : DC (-VE)

## Chemical Composition of Wled Metal (wt %)

	C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
Typical Results	0.07 max	0.9-1.4	0.40-0.70	0.030 Max	0.025 Max	0.05-0.15	0.02-0.12	0.05-0.15	0.50 Max

## All Weld Metal Mechanical Properties :-

	UTS (mpa)	YS (mpa)	Elongation % (L=4xd)	CVN impact at -30C
Typical Results	480 min	400 min	22 min	28 J min.

Packing Details :- 1000mm cut length with 1 side embossed grade.

1.60mm x 1mtr	2.0mm x 1mtr	2.40mm x 1 mtr	3.2mm x 1 mtr	4.00mm x 1mtr
5 kg	5 kg	5 kg	5 kg	5 kg

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