

ES TIG 70S-6

GTAW
ER70S-6

ESWECO
The Art of Welding

Description

ES TIG 70S-6 is a copper-coated Mn-Si alloyed W3Si1/ER70S-6 solid rod for the GTAW of non-alloyed steels, as used in general construction, pressure vessel fabrication and shipbuilding.

Current

DC (-)

Classifications

SFA/AWS A5.18	ER70S-6
EN 1668	W3Si1

Typical all weld metal composition, %

C	Si	Mn
0.1	0.9	1.5

Typical mech. Properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	560
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
-30	70

Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5
2.0	1000	5
2.4	1000	5
3.2	1000	5
4.0	1000	5