

TG 2

TIG Welding Wire - Non Alloyed Steels

Standards	
AWS/ASME SFA - 5.18	ER70S-6
EN ISO 636 - A	W 42 2 3Si1
TS EN ISO 636 - A	W 42 2 3Si1
DIN M. No.	1.5125

Approvals & Certificates		
TL TUV CE-DoP CE	UKCA DNV BV	DB UKCA-DoP CWB

Materials	
EN	DIN
S185 - P355T1	St 33.0 - St 52.0
S235J2 - S355J0	St 37.3 - St 52.3
P235TR2 - P235T2	St 37.4 - St 52.4
P235G1TH - P255G1TH	St 35.8 - St 45.8
E295	St 50.2
P235GH - P265GH	H I - H II
P295GH, P355GH	17Mn4, 19Mn5
L210 - L360NB	StE 210.7 - StE 360.7
GE 200, GE 240, GE 260	GS 38, GS 45, GS 52
S255N - S380N	StE 255 - StE 380
	A, B, D, E
	X42, X46

Properties and Applications

GTA (TIG) welding rod for unalloyed steels, fine grained steels and pipes. Particularly used in root and cap passes in chemical, petrochemical, water, natural gas pipes joints safely. Suitable also welding of thin metal plates, tanks, boilers and repair welds of them. Thin and homogeneous copper coating increase resistance to rusting.



Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn
Welding Wire	0.06	0.80	1.45

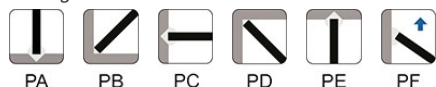
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	I1	480	560	28	-20°C → 95	-30°C → 80

* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



PA

PB

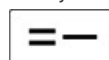
PC

PD

PE

PF

Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (~)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
21102GBKM2	1.60x1000	5	5.0	4	21.4	Cardboard Tube
21102HBKM2	2.00x1000	5	5.0	4	21.4	Cardboard Tube
21102LBKM2	3.20x1000	5	5.0	4	21.4	Cardboard Tube
21102MBKM2	4.00x1000	5	5.0	4	21.4	Cardboard Tube

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.