

GTAW**For Mild and High Tensile Steel****MC-70S-6 (TIG)**

CLASSIFICATION : AWS A5.18 ER70S-6

JIS Z3316 YGT 50

WELDING POSITIONS :

**DESCRIPTION AND APPLICATIONS**

It is designed for welding of mild and high tensile steel or 490 N/mm² grade steel. Commonly used for butt and fillet welding of high pressure piping for shipbuilding, petrochemical and etc. Also is an all-position welding rod for TIG welding. Suitable for root pass of pipe welding.

NOTES ON USAGE

- 1) Use DC (-) polarity.
- 2) Welded with Pure Argon as the shielding gas.

WIRE ANALYSIS (Wt%)					
C	Mn	Si	P	S	Fe
0.09	1.45	0.88	0.012	0.010	Bal

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES •			
YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
510 N/mm ²	580 N/mm ²	29%	80J@ -20°C

• in "as welded" condition.

PRODUCT NAME	SIZE (mm)	PACKAGING (Kg)
MC-70S-6 (TIG)	1.2/1.6/2.0/2.4/3.2	5