

GTAW**For Mild and High Tensile Steel****MC-70S-4 (TIG)**

CLASSIFICATION : AWS A5.18 ER70S-4

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. It is suitable for root pass welding of pipes and all welding of thin plates.

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
0.08	1.15	0.77	0.012	0.008	Bal

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES •

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
450 N/mm ²	560 N/mm ²	28%	75J@ -20°C

• in "as welded" condition.

PRODUCT NAME	SIZE (mm)	PACKAGING (Kg)
MC-70S-4 (TIG)	1.6/2.0/2.4/3.2	5