

**ROYAL – Tig – T2 (ER 70S-2)**

AWS A/ SFA 5.18 Class ER 70S-2

**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

**Characteristics on Usage**

Triple deoxidized mild steel wire smooth flow, stable arc and minimum spatter under optimum welding conditions. Gives radiography quality welds

**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Zr%
0.07 Max	0.90 – 1.40	0.40 – 0.70	0.035- Max	0.025 Max	0.15 Max	0.15 Max	0.02-

**Mechanical Properties Of Weld Metal**

U.T.S.	Y.S.	ELONGATION	IMPACT ( CVN )
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L = 4d ) %	AT - 30° C ( J )
480	400	22	27

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET
1.20 x 1000	5
1.60 x 1000	5
2.00 x 1000	5
2.50 x 1000	5