

AUTOTHERME 70S-2 (NACE)

CODIFICATION: AWS : SFA 5.18 ER70S-2

CHARACTERISTICS AND APPLICATIONS:

Autotherme 70S-2 (NACE) is triple deoxidized copper coated mild steel wire for GMAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is designed for single and multi-pass welding of low and medium carbon steels. Ideal for welding A36, A285 Gr. C, A333 Gr.6, A515-55, A516-70, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	P	S	Ti	Zr	V	Al	Cu	Ni	Cr	Mo
%	0.05	1.25	0.55	0.010	0.008	0.10	0.09	0.01	0.09	0.06	0.10	0.10	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L=4d) %	CVN Impact Strength At minus 46°C (Joules)
530	440	28.0	45

CORROSION TEST: Passes corrosion test as per NACE standard TM-01-77-96 (SSCC) and TM-02-84-96 (HIC)

HARDNESS OF WELD METAL : 200 HV5 MAX.

WELDING PARAMETER : DC(+)

Diameter	Flat	
	Volt, V	Current, A
0.8 mm	28-32	170-200
1.2 mm	27-31	260-290
1.6 mm	26-30	330-360

SHIELDING GAS : Ar / CO₂

WELDING POSITION : H, F, VU, OH

PACKING :

STANDARD SIZE	Diameter 0.8 mm, 1.2 mm & 1.6 mm
QUANTITY	15.0 kg wire, random/ layer wound in a plastic spool that conforms to DIN-8559 SD-300.