



F 70S-2

CODIFICATION : **AWS :** SFA 5.18 ER70S-2

CHARACTERISTICS AND APPLICATIONS:

F 70S-2 is triple deoxidized copper-coated mild steel wire for GTAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is suitable for root run of mild steel pipes. Ideal for welding A36, A285 grade C, A515-55, A516-70, etc

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	P	S	Ti	Zr	Al	Cu	Ni	Cr	Mo
%	0.05	1.25	0.55	0.02	0.02	0.10	0.09	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 30°C (Joules)
530	440	28.0	60

SHIELDING GAS: Argon

CURRENT CONDITIONS: DCEN

WELDING POSITION: H, F, VU, OH

APPROVAL: Adani Infra, CIB-MP, L&T Power, NPCIL, PDIL, Reliance
(Engineering)

PACKING:

STANDARD SIZE Diameter 1.6 mm, 2.0 mm, 2.4 mm, 2.5 mm, 3.15 mm &
3.2 mm in cut lengths of 500 mm / 1000 mm each.

QUANTITY 5 kg wire put in an air-tight polythene bag and finally
packed in a plastic container.

Identification-AWS code is punched on each wire.