

F 70S-2 (NACE)

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

CHARACTERISTICS AND APPLICATIONS:

F 70S-2(NACE) 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 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.

SHIELDING GAS: Argon

CURRENT CONDITIONS: DCEN

WELDING POSITION: H, F, VU, OH

PACKING:

STANDARD SIZE	Diameter 1.6 mm, 2.0 mm, 2.4 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.