

Gas Tungsten Arc Welding

TG-S51T
FAMILIARC

TIG welding rod and wire for mild steel, 490MPa high tensile strength steel and aluminium-killed steel for low temperature service

Classification: ASME / AWS A5.18 ER70S-6
JIS Z3316 YGT50

Features: •Its tensile strength after long time PWHT is high enough for 490MPa

Shielding Gas: Ar

Polarity: DC-EN

Chemical composition of rod and wire (%) as per AWS

	C	Si	Mn	P	S	Cu	Al	Ti	Zr
Example	0.10	0.89	1.56	0.010	0.011	0.23	0.01	0.01	0.01
Guaranty	0.07~ 0.15	0.80~ 1.00	1.40~ 1.85	≤0.025	≤0.025	≤0.50	≤0.15	≤0.15	≤0.12

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°C×h)
Example	510	610	32	-29°C: 210	AW
	420	550	35	-29°C: 160	625x24
Guaranty	≥400	≥480	≥22	-29°C≥27	AW

Approvals

Others

TÜV

Packages

Dia. (mm)	Type	Weight (kg)	Length (mm)	Weight/ piece(g)
0.8	spool	10	-	-
1.2	spool	10	-	-
1.6	tube	5	1,000	16
2.0	tube	5	1,000	25
2.4	tube	5	1,000	35
3.2	tube	5	1,000	63