

Gas Tungsten Arc Welding

TG-S3N
FAMILIARC
TIG Welding Rods and Wires for 3.5%Ni Low Temperature Steel
Classification: ASME / AWS A5 28 ER70S-G

Features : Applied for :-

Plate : BS1501 Gr. 503 and A203 Gr. D,E,F

Forgings : BS1503 Gr. 503 and ASTM A350 Gr. LF3

Castings : BS1504 Gr. 503 LT60 and ASTM A352 Gr. LC3

Pipe : ASTM A333 Gr. 3

Shielding Gas : Ar

Polarity : DC-EN

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

	C	Si	Mn	P	S	Ni	Mo	Cu
Example	0.04	0.36	0.89	0.004	0.00	3.48	0.15	0.11
Guaranty	≤ 0.06	≤ 0.60	0.60~ 1.10	≤ 0.020	≤ 0.020	3.20~ 3.90	≤ 0.30	≤ 0.50

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°C×h)
Example	510	580	30	-101°C: 69	AW
	490	570	31	-101°C: 78	620x1
Guaranty	≥360	≥480	≥24	-105°C≥27	AW
	≥360	≥480	≥24	-105°C≥27	620±15x1

Packages

Dia. (mm)	Type	Weight (kg)	Length (mm)	Weight per piece (g)
1.6	Tube	5	1000	16
2.0	Tube	5	1000	25
2.4	Tube	5	1000	35