TIG F58

Classification

AWS A5.18 : ER70S-6 ISO 636-A : W 46 5 4Si1

Description & Applications

Copper coated TIG rod to weld low alloyed standard construction / boiler steels like S235-S355, P235-P355 and S255N-S420N.

Main applications: For pipping (in particulary Nuclear) for root pass for high quality level of welding with specific control.

Base material:

Construction steels for general use, Tube steels, Ship steels:

EN	*Ship steels*	*ASTM*
S185 – S355	Quality A and B	A285 grade C
P235 – P355		A442 grade 55, 60
L210 – L360		A414 grade C, D, E, F
		A515 grade 55, 60, 65

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti+Zr	V	P	S	Fe
Min	0.06	0.80	1.60										
Max	0.14	1.15	1.85	0.15	0.15	0.15	0.35	0.02	0.15	0.03	0.025	0.025	Rem.
Type	0.08	0.90	1.70	0.04	0.04	0.008	0.15	0.006	0.01	0.001	0.01	0.01	Rem.

All Weld Metal Mechanical Properties

	R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	460	530	22	-50°C	>47
Max		680			
Type	530	620	26	+20°C -30°C -60°C	160 110 60

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175: I1 (Ar) 6-12 l/min Back shielding : I1 (Ar) / N1 (Nitrogen) 3-6 l/min

FT En-TA08-160829

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