

ER 70S-2

Mild Steel TIG/GTAW

Standards

EN/ISO-Standard - 636-A
EN/ISO-Classification - W 2Ti

AWS-Standard - A5.18
AWS-Classification - ER 70S-2

Features and Applications

- Micro-alloyed steel, triple de-oxidised (Ti, Al, Zr) suitable for the welding of C-Mn and low-alloy steels.
- Ideal for use on greasy and oxidised surfaces subsequent to any coating processes. (i.e. galvanised steel)
- Works well at low temperatures.
- Typically used on tanks, containers, car industry, structural work, household appliances, pipelines, boilers, naval & petrochemical sectors etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

A106, A210, A234 S355J2, S380N, P235GH, GS 45, P295GH, P355GH, S355N*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

TIG DC (-)

Mechanical Properties (Typical)

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)	Test Temperature
560	480	24	>50	-30°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition of Weld Metal % (Typical)

C %	Si %	Mn %	P %	S %	Cu % ^a	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.06	0.60	1.20	<0.020	<0.020	<0.25	<0.10	<0.10	<0.050	0.100	<0.030	<0.15

^a (includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
3010300219	1.00	1000	5	Cardboard Tube
3010300221	1.20	1000	5	Cardboard Tube
3010300222	1.60	1000	5	Cardboard Tube
3010300224	2.40	1000	5	Cardboard Tube
3010300225	3.20	1000	5	Cardboard Tube

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