

Classifications

EN 636-A:2008	: W 46 3 W3Si1	JIS Z 3316	: W 49 A 3U 6
EN 636-B:2008	: W 49A 3 U W6	KS D 7140	: YGT50
AWS A5.18-05	: ER70S-6		

Description

- For mild steel and 490MPa tensile strength steel welding of structural steels, machineries and vehicles.
- Excellent mechanical and toughness properties in low temperature conditions.
- It is generally used in root pass welding of pipes in all positions.
- Proper tungsten electrode extension from the tip of torch is 4-6mm in general.

Typical chemical composition of rod (%)

C	Si	Mn	P	S
0.07	0.82	1.52	0.012	0.015

Typical mechanical properties of all-weld-metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30°C	Remarks
AWS A5.18	min. 400	min. 480	min. 22	≥ 27	Ar
EN 636-A	min. 460	530~680	min. 20	≥ 47	Ar
Example	490	580	30	130	Ar

Operating data

Dia.(mm)	2.4~3.2
Current (Amp.)	200 ~ 300

Polarity and Shielding gas

- DCEN (DC-)
- Ar : (15~25ℓ/min)

Approvals

Shielding gas	ABS	LR	KR
Ar	2YSA	4YMH15	RSW54G