

# TG 2

TIG Welding Wire - Non Alloyed Steels

| Standards           |             |
|---------------------|-------------|
| AWS/ASME SFA - 5.18 | ER70S-6     |
| EN ISO 636 - A      | W 42 2 3Si1 |
| TS EN ISO 636 - A   | W 42 2 3Si1 |
| DIN M. No.          | 1.5125      |

| Approvals & Certificates |      |        |
|--------------------------|------|--------|
| CWB                      | UKCA | BV     |
| CE                       | TUV  | DNV    |
| UKCA-DoP                 | DB   | CE-DoP |
| TL                       |      |        |

| Materials              |                       |
|------------------------|-----------------------|
| EN                     | DIN                   |
| S185 - P355T1          | St 33.0 - St 52.0     |
| S235J2 - S355J0        | St 37.3 - St 52.3     |
| P235TR2 - P235T2       | St 37.4 - St 52.4     |
| P235G1TH - P255G1TH    | St 35.8 - St 45.8     |
| E295                   | St 50.2               |
| P235GH - P265GH        | H I - H II            |
| P295GH, P355GH         | 17Mn4, 19Mn5          |
| L210 - L360NB          | StE 210.7 - StE 360.7 |
| GE 200, GE 240, GE 260 | GS 38, GS 45, GS 52   |
| S255N - S380N          | StE 255 - StE 380     |
|                        | A, B, D, E            |
|                        | X42, X46              |

## Properties and Applications

GTA (TIG) welding rod for unalloyed steels, fine grained steels and pipes. Particularly used in root and cap passes in chemical, petrochemical, water, natural gas pipes joints safely. Suitable also welding of thin metal plates, tanks, boilers and repair welds of them. Thin and homogeneous copper coating increase resistance to rusting.



## Typical Chemical Features of the Welding Wire

| Type of Analysis | C    | Si   | Mn   |
|------------------|------|------|------|
| Welding Wire     | 0.06 | 0.80 | 1.45 |

## Typical Mechanical Values of Weld Metal

| Test Condition | Protection Gas | Yield Strength (N/mm <sup>2</sup> ) | Tensile Strength (N/mm <sup>2</sup> ) | Elongation A5 (%) | Charpy V-Notch Properties (J) |            |
|----------------|----------------|-------------------------------------|---------------------------------------|-------------------|-------------------------------|------------|
| As welded      | It             | 480                                 | 560                                   | 28                | -20°C → 95                    | -30°C → 80 |

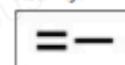
\* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - It (%100 Ar) .

## Application Information

### Welding Positions



### Polarity:



Protection Gas:  
It

### Welding Parameters & Efficiency

### Packaging Information

| Product Code | Diameter X Length (mm) | Pieces per Box (-) | Weight Of The Box (kg) | Boxes Per Package | Weight Of The Package | Packaging Type |
|--------------|------------------------|--------------------|------------------------|-------------------|-----------------------|----------------|
| 21102GBKM2   | 1.60x1000              | 5                  | 5.0                    | 4                 | 21.4                  | Cardboard Tube |
| 21102HBKM2   | 2.00x1000              | 5                  | 5.0                    | 4                 | 21.4                  | Cardboard Tube |
| 21102LBKM2   | 3.20x1000              | 5                  | 5.0                    | 4                 | 21.4                  | Cardboard Tube |
| 21102MBKM2   | 4.00x1000              | 5                  | 5.0                    | 4                 | 21.4                  | Cardboard Tube |

### Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.