FOR HIGH TENSILE STRENGTH STEEL

TIG, MIG WELDING CONSUMABLES

AWS ER70S-6
EN G2Si1
JIS YGT50

T-50

Typical applications
This rod uses TIG welding on all grades of carbon steel. It is generally used in root pass welding of pipes in all positions.

Characteristics on Usage
① Excellent mechanical and toughness properties in low temperature conditions.
② Argon gas is mainly used for the shielding.
③ Proper tungsten electrode extension from the tip of torch is 4~6mm in general.

Typical chemical composition of rod (%)

<table>
<thead>
<tr>
<th>C</th>
<th>Si</th>
<th>Mn</th>
<th>P</th>
<th>S</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.07</td>
<td>0.82</td>
<td>1.52</td>
<td>0.010</td>
<td>0.010</td>
</tr>
</tbody>
</table>

Typical mechanical properties of all-weld-metal

<table>
<thead>
<tr>
<th>Y · P</th>
<th>T · S</th>
<th>EI</th>
<th>Charpy V-notch</th>
</tr>
</thead>
<tbody>
<tr>
<td>N/mm² (kgf/mm²)</td>
<td>N/mm² (kgf/mm²)</td>
<td>(%)</td>
<td>J (kgf · m) (-29°C)</td>
</tr>
<tr>
<td>490 (50)</td>
<td>580 (59)</td>
<td>30</td>
<td>130 (13)</td>
</tr>
</tbody>
</table>

Approved by
ABS

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