

**TECHNICAL DATA SHEET**

ERIALS

S.T.

Rev.

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NOME DEL PRODOTTO:
NAME OF PRODUCT**ELB-TIG****CLASSIFICAZIONI:**
CLASSIFICATIONAWS A5.18: ER70S-6
EN ISO 636-A- W 42 4 W3Si1**CARATTERISTICHE MECCANICHE TIPICHE / TYPICAL MACHANICAL PROPERTIES**

Rm (N/mm ²)	Rs (N/mm ²)	Al% 5d	Kv + 20 °C J	Kv - 40 °C J
550	450	> 24		> 80

ANALISI CHIMICA MEDIA / CHEMICAL COMPOSITION (average)

C %	Si %	Mn%	P %	S %	Cu %	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti%
0,070	0,85	1,45	<0,020	<0,020	< 0,25	<0,15	<0,15	< 0,05	<0,020	<0,030	< 0,15

*Il valore del rame (Cu) comprende il rivestimento superficiale / Cu including copper coating***PROCEDIMENTI DI SALDATURA / WELDING PROCESS**

Gas di protezione / Shielding gas	Argon
Corrente e polarità / Current and Polarity	DC -
Posizioni di saldatura / Welding Position	EN ISO 6947: PA, PB, PC, PD, PE, PF, PG

PARAMETRI DI SALDATURA / WELDING PARAMETERS

σ	A	V

DIMENSIONI / DIMENSIONS

MIG (mm)	1,00	1,20	1,60	2,00	2,40	3,00	3,20

IDENTIFICAZIONE / IDENTIFICATION

External label and stamping on each TIG rod

CONSERVAZIONE / STORAGE

Dry place. Suggested stored time not exceeding 4 months.

OMOLOGAZIONI / APPROVALS

CE Marking acc to EN 13479

BASE MATERIALS

Standard	Type
EN 10025	S185, S235, S275, S355
ASTM A131	Grade A, B, D, AH32 to DH36
EN 10208	L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB
API 5LX	X42, X46, X52, X60
EN 10216	P235T1, P235T2, P275T1
EN 10217	P275T2, P355N
EN 10028	P235GH, P265GH, P295GH, P355GH
EN 10025	S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML

APPLICATIONS

Vessels, boilers fabrication, industrial machinery construction, metal working industry, pipes fabrication, car production, coachbuilders.