



MODI TIG 70S-2 Copper Coated Mild Steel TIG Wire

CLASSIFICATION : AWS/A 5.18 : ER 70S-2

CHARACTERISTICS & APPLICATIONS : Copper coated 'triple deoxidized' steel welding wire recommended for high quality Gas Tungsten Arc (TIG) welding of carbon and carbon Manganese steels. It is deoxidized with Titanium, Aluminium and Zirconium in addition to Manganese and Silicon for improved weld deposit quality. Produces radiographic quality welds.

Ideal choice for TIG welding of rusty or mill scaled plates and pipes. Root pass welding of pipes, tanks and heavy walled joints where good root toughness is achieved under high dilution.

CHEMICAL ANALYSIS OF WIRE (%)	C	Mn	Si	Ti	Zr
	0.07 max	0.90-1.40	0.40-0.70	0.05-0.15	0.02-0.12
	Al	S	P		
	0.05-0.15	0.035 max	0.025 max		

MECHANICAL PROPERTIES OF ALL WELD DEPOSIT	Yield	Ultimate	Elongation	CVN Impact
	Strength	Tensile		Values @-29°C
		Strength		
	(N/mm ²)	(N/mm ²)	(%)	(Joules)
	400 min	480 min	22	27

PACKING SPECIFICATION :

Wire Size(mm)	1.6x1000	2.0x1000	2.4x1000	3.15x1000
Pack Weight/Tube (Kg)	5.25	5.25	5.25	5.25
Weight/Box	21.0	21.0	21.0	21.0



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