

FOR HIGH TENSILE
STRENGTH STEEL

AWS ER70S-3
EN G2Si
JIS YGT50

T-53

Typical applications

This rod uses TIG welding on all grades of carbon steel. It is generally used in root pass and to support the welding when back pass is impossible.

Characteristics on Usage

- ① Excellent mechanical and toughness properties in low temperature conditions.
- ② Ar gas is mainly used for the shielding.

Typical chemical composition of rod (%)

C	Si	Mn	P	S
0.07	0.65	1.18	0.010	0.009

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	El (%)	Charpy V-notch J {kgf · m} (-29°C)
480 {49}	550 {56}	32	120 {12}

Approved by