

# GETIG 70S2 (SPL)

**IDENTIFICATION: ER 70S2 NACE GRADE TIG FILLER WIRE**

**APPROVED BY: EIL at IOCL Gujarat Refinery, Vadodara**

**CLASSIFICATION:** AWS A5.18 Class ER70S-2

**DESCRIPTION:**

Copper coated filler wire has Al, Ti, Zr as strong deoxidants with Mn and Si content. This has advantages of semi-killed steels or rusty and contaminated joint area. Smooth flow and gives shiny bead under optimum welding conditions. The deposited weld meet x-ray / radiographic quality code requirement.

**COMPOSITION OF THE WIRE (RANGE) %**

C	Mn	Si	Zr	Al
0.07 max	0.9-1.4	0.40-0.70	0.02-0.12	0.05-0.15
Ti	S	P	Mo	Ni
0.05-0.15	0.012 max	0.015 max	0.15 max	0.15 max
Cu		Cr	V	
0.5 % Max (including coating)		0.15 max	0.03 Max	

**TYPICAL APPLICATIONS**

- For welding of structural, pressure vessels and boilers involving unalloyed and micro alloyed structural steel with specified tensile strength up to 520N/mm<sup>2</sup> to meet subzero Impact requirements down to -29° C.
- ASTM A 36, A106 A/B/C, A139 etc

**MECHANICAL PROPERTIES (RANGE)**

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact Values	
			Temp	Joules
510-620	410-550	22-28	-29°C	30-90

**CORROSION TEST:**

Passes corrosion test as per NACE standard TM-01-77 AND TM-02-84, GS-8 Annexure 1 of EIL specification.

**SHIELDING GAS:** Pure Argon

**PACKING DATA:**

SIZE (mm)	LENGTH (mm)	PACKING/BOX
1.6	1000	5 Kg
2.00	1000	5 Kg
2.40/2.50	1000	5 Kg
3.15/3.20	1000	5 Kg

Note: Length / Diameter can be given as per the party's requirement  
Chemical Analysis and Mechanical

**Manufactured by: GEE LIMITED**

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