



KISWEL

KISWEL – T-70S2

Classifications:

AWS A5.18-05: ER70S-2

EN 636-A: 2008: W 46 3 W2Ti

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Ti	Zr	Al
<0.07	0.40 – 0.70	0.90 – 1.40	0.05 – 0.15	0.02 – 0.12	0.05 – 0.15

Description:

- For mild steel and 490MPa tensile strength steel welding of pipes, offshore drilling rigs and structural steels, etc.
- It is a multiple deoxidized rod containing small amounts of zirconium, titanium and aluminium in addition to the manganese and silicon deoxidizers characteristic of steel rod group.
- Weld Deposits are of superior quality with minimum porosity.

Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 400	min. 480	min. 22	180 (-30°C)

Packaging:

GTAW Wire (Ø in mm): 1.60 MM / 2.00 MM / 2.40 MM / 3.20 MM in 5.00 Kg Packing

Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
1.60 mm	Ar	90	170	11	16
2.00 mm		90	180	12	18
2.40 mm		100	200	13	20
3.20 mm		120	250	13	22



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