

MIG GAS-SHIELDED WELDING WIRE 气保焊镀铜实心焊丝

Model Name	Standard	Chemical composition	Mechanical Properties	Description
ER70S-4	AWS A5.18 ER70S-4 JIS Z3312 YGW-12 GB/T8110 ER50-4	C 0.090 Mn 1.06 Si 0.55 P 0.014 S 0.011	$\delta b \geq 550\text{MPa}$ $\delta s \geq 460\text{MPa}$ $\delta 5 \geq 32\%$ $Akv(J) \geq 84(-29^{\circ}\text{C})$	When welded under the operating condition of low current ER70S-4 spatters little spark and have stable electric arc; Uses Ar+CO ₂ as shielding gas for all-position welding or high-speed single-layer back welding.
ER70S-G	AWS A5.18 ER70S-G JIS Z3312 YGW-11 GB/T8110 ER50-G	C 0.088 Mn 1.55 Si 0.77 P 0.016 S 0.013 other 0.23	$\delta b \geq 620\text{MPa}$ $\delta s \geq 550\text{MPa}$ $\delta 5 \geq 30\%$ $Akv(J) \geq 98(-29^{\circ}\text{C})$ $Akv(J) \geq 85(-40^{\circ}\text{C})$	In addition to appropriate amount of Si, Mn, the addition of Ti to ER70S-G would refine the globular grain of weld wire and help stabilize electric arc; In comparison, spark spatters and smog is reduced by a large margin. Not only does Ti contribute to refinement of weld bead grain, it also increases the strength of weld bead and impact value. Under the operating condition of high current.
ER80S-G	AWS A5.58 ER80S-G JIS Z3312 YGW-21 GB/T8110 ER55-D2-Ti	C 0.081 Mn 1.44 Si 0.61 P 0.020 S 0.010 Mo 0.37	$\delta b \geq 650\text{MPa}$ $\delta s \geq 560\text{MPa}$ $\delta 5 \geq 26\%$ $Akv(J) \geq 175(-40^{\circ}\text{C})$ $Akv(J) \geq 80(-60^{\circ}\text{C})$	ER80S-G is suitable for welding of 590MPa high tensile steels. Applicable to wide current range and stable electric arc, it is primarily applied to the welding of high tensile structural steels.
ER49-1	GB/T ER49-1	C ≥ 0.11 Mn 1.80-2.10 Si 0.65-0.95	$\delta b \geq 570\text{MPa}$ $\delta s \geq 460\text{MPa}$ $\delta 5 \geq 22\%$ $Akv(J) \geq 27(-30^{\circ}\text{C})$	For construction machines, vehicles, boilers, elevators etc.

Package Size:

Wire Diameter(mm)	0.6	0.8	0.9	1.0	1.2	1.6	2.0
Weight(kg)/spool	0.9/5.0	0.9/5.0/15.0		15.0			
Diameter(mm)/spool	0.9kgs/D100, 5kgs/D200, 15kgs/D270, 15kgs/D300						

TIG GAS-SHIELDED WELDING WIRE 氩弧焊镀铜实心焊丝

Model Name	Standard	Chemical composition	Mechanical Properties	Description
ER70S-G	AWS A5.18 ER70S-G JIS Z3316 YGT-50 GB/T8110 ER50-G	C 0.065 Mn 1.47 Si 0.60 P 0.015 S 0.012	$\delta b \geq 560\text{MPa}$ $\delta s \geq 450\text{MPa}$ $\delta 5 \geq 31\%$ $Akv(J) \geq 186(-29^{\circ}\text{C})$	Suitable for butt joint welding and fillet welding of mild steels and 490MPa high tensile steels in the industries of shipbuilding, petrochemistry and nuclear power plant where high voltage equipment exists. SJ-50 uses argon gas as TIG shielding gas. It is suitable for all-position welding, especially for the first bead back welding of pipes. The welding is powered by DC negative electrode (DC-).
ER70S-2	AWS A5.18 ER70S-2 JIS Z3316 YGT-50 GB/T8110 ER50-2	C 0.040 Si 0.46 S 0.008 Ti 0.06 Zr 0.04 Mn 1.21 P 0.010 Al 0.06	$\delta b \geq 540\text{MPa}$ $\delta s \geq 470\text{MPa}$ $\delta 5 \geq 30\%$ $Akv(J) \geq 186(-29^{\circ}\text{C})$	Suitable for welding of mild steel and 490MPa high tensile steels. Thanks to the addition of Al, Ti, Zr it is characterized by excellent welding performance when applied to all-position back welding of pipe fittings.

Package Size:

Wire Diameter(mm)	1.6	2.0	2.5	3.2	3.8	4.8	6.4
Length(mm)	1000						
Packing	5kgs/PVC box, 20kgs/carton/pallet						