

TIG rod
Unalloyed

AX-WSG3

Material no.: 1.5130

Standards

EN ISO 636-A:	W 46 4 W4Si1
AWS A5.18:	ER70S-6

Properties

Welding rod for joining of unalloyed and low-alloyed Steels in boiler, container, building and vehicle construction.

Important base materials / Important applications

S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S460N, S275M-S460M, S275NL-S460NL, S275ML-S460ML, P235GH-P355GH, P275NL1-P460NL1, P275NL2-P460NL2, P215NL, P265NL, P355N, P460N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L245MB-L415MB, GE200-GE240.

ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1, LF2; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. A, C, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 711 Gr. 1013; A 841 Gr. A, B, C; API 5 L Gr. B, X42, X52, X56, X60.

Typical composition of welding rod in %

C	Si	Mn
0,08	0,9	1,7

Mechanical properties of all-weld metal (typical values)

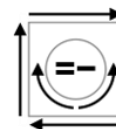
Yield strength $R_{p0,2}$	[MPa]	490
Tensile strength R_m	[MPa]	580
Elongation A ($L_0 = 5d_0$)	[%]	26
Impact work KV	[J]	75 at -40°C

Shielding gas: 100% Argon, PWHT: untreated

Operating data

TIG:

Shielding gas: I1 (100%Argon)
acc. to ISO 14175



Approvals

(Please ask for current scope)

Packaging and available sizes

Rods	Ø mm x 1000mm	1,6	2,0	2,4	3,2		
------	---------------	-----	-----	-----	-----	--	--

Other dimensions on request