

FOR HIGH TENSILE
STRENGTH STEEL

AWS ER70S-6
EN G2Si1
JIS YGT50

T-50

Typical applications

This rod uses TIG welding on all grades of carbon steel.
It is generally used in root pass welding of pipes in all positions.

Characteristics on Usage

- ① Excellent mechanical and toughness properties in low temperature conditions.
- ② Argon gas is mainly used for the shielding.
- ③ Proper tungsten electrode extension from the tip of torch is 4~6mm in general.

Typical chemical composition of rod (%)

C	Si	Mn	P	S
0.07	0.82	1.52	0.010	0.010

Typical mechanical properties of all-weld-metal

Y · P	T · S	EI	Charpy V-notch
N/mm ² {kgf/mm ² }	N/mm ² {kgf/mm ² }	(%)	J {kgf · m} (-29°C)
490 {50}	580 {59}	30	130 {13}

Approved by
ABS