NO65G FAMILIARC™

TIG welding rod and wire

Features: ▪ Suitable for root pass welding of pipes

Classification: AWS A5.18 ER70S-2

Shielding Gas: Ar
Identification color: 1st Blue white
Polarity: DCEN

Packaging data

	Spool		Tube		
ϕ mm	**kg**		**kg**	**Length mm**	**g/piece**
0.9	10	-	-	-	-
1.0	10	-	-	-	-
1.2	-	-	5	1,000	9
1.6	-	20	5	1,000	16
2.0	-	-	5	1,000	25
2.4	-	-	5	1,000	35
3.2	-	-	5	1,000	63
Volume mm	240W, 110H, 230L	280W, 110H, 270L	40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.04	0.07
Si	0.54	0.40~0.70
Mn	1.25	0.90~1.40
P	0.007	0.025
S	0.014	0.035
Ni	0.04	0.15
Cr	0.05	0.15
Mo	0.01	0.15
Cu	0.16	0.50
V	<0.01	0.03
Al	0.07	0.05~0.15
Ti	0.08	0.05~0.15
Zr	0.05	0.02~0.12

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	560	520	400min.
TS (MPa)	620	600	483min.
El on 4d (%)	28	30	22min.
IV -29℃ (J)	200	160	27min.
PWHT (℃xh)	AW	625x8	AW