TG-S3N TRUSTARC™

TIG welding rod and wire

Features: ▪ Suitable for 3.5% Ni steel

Classification: AWS A5.28 ER70S-G

Shielding gas: Ar
Identification color: 1st Yellowish green
Polarity: DCEN

Packaging data

	Spool	Tube		
ϕ mm	**kg**	**kg**	**Length mm**	**g/piece**
1.2	10	-	-	-
1.6	-	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	40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.02	0.06
Si	0.34	0.60
Mn	0.86	0.60~1.10
P	0.004	0.020
S	0.008	0.020
Ni	3.53	3.20~3.90
Mo	0.15	0.30
Cu	0.17	0.35

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	Wire	Rod
1.2	50~280	-
1.6	-	60~220
2.0	-	80~240
2.4	-	100~260
3.2	-	150~300

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	510	490	360min.
TS (MPa)	580	570	483min.
El on 4d (%)	30	31	24min.
IV -101℃ (J)	350	345	-105℃: 27min.
PWHT (℃xh)	AW	620x1	AW & 620±15x1