TG-S60A TRUSTARC™

TIG welding rod and wire

Features: ▪ Suitable for 550 to 610MPa tensile strength steel

Classification: AWS A5.28 ER80S-G

Shielding gas: Ar
Identification color: 1st Orange
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
Volume mm	240W, 110H, 230L	40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.10	0.12
Si	0.05	0.20
Mn	1.43	1.00~1.60
P	0.004	0.025
S	0.007	0.025
Ni	0.82	0.60~1.00
Mo	0.58	0.30~0.65
Cu	0.15	0.50

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

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	590	590	420min.
TS (MPa)	670	660	552min.
El on 4d (%)	28	30	18min.
IV -60℃ (J)	270	280	27min.
PWHT (℃xh)	AW	600x1	AW & 600±15x1

Approvals

ABS	5YQ460SA
LR	5Y46m, H5
DNV	ⅤY46MS