

AK ER70S-A1

Description: ER70S-A1 is a copper-coated solid wire for GTAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is ideally suited for welding of low alloy ferritic steels of similar composition. The weld metal possesses good high temperature properties. Typical applications include the welding of Carbon Molybdenum steels such as, ASTM Grade F1 of SA-182 & SA-336, Grade A of SA-204, Grade T1/T1a/T1b of SA-209, Grade WC1 of SA-217, Grade A of SA-302, Grade P1 of SA-335, Class 1 of A grades of SA-533, etc

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.12	0.30-0.70	1.30	0.025	0.025	0.20	0.35	0.40-0.65	0.35
Actual Result	0.072	0.53	0.88	0.008	0.010	0.010	0.16	0.56	0.16

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 515	≥400	≥ 19	≥27J(-20℃)
Actual Result	555	450	25	102 110 106