

**TIG Wires for C- Mn
Steels Welding**





AMA 40-13T

Standards: AWS/ASME SFA - 5.18 ER70S-3

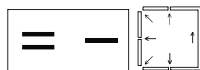
Application/ Properties: Low alloy wire electrode for TIG- Welding of general structural steels and pipe steels using Ar shielding gas.

Analysis of Wire electrode% (Typical value):

C	Si	Mn	P	S
0.06-0.12	0.45-0.75	0.9-1.4	≤0.025	≤0.025

Mechanical properties of all-weld metal using Ar shielding gas (single value are typical values) :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A4 (%)	Impact energy Joule ISO - V -18 °C
>420	500-640	>22	>27



Material:

Unalloyed Structural steels	DIN 17 100	St 33, St 37-2 to St 52-3 St 50*, ST 60*,St 50-2*, ST 60-2*
Pipe steels	DIN 1626/1629 DIN 1628/1630 DIN 17175 DIN 17172	St 37.0 to St 52.0 St 37.4 to St 52.4 St 35.8 to St 45.8, St 55*,St 55-4 StE 210.7 to StE 360.7
Fine grain structural steels	DIN 17 102 DIN1629	StE 255 to StE 355 WStE 255 to WStE 355 TStE 255 TO TStE 355
Boiler plates Shipbuilding steels casting steels	DIN 17 155	HI, HII, 17 Mn 4, 19Mn5* A, B, D, E GS-38, GS-45, GS-52
API Standards	API Standard	X42, X46

* Depending on plate thickness, preheat 150-300°C
 Delivery: Welding rods, Copper coated:
 weight :5 or 10 kg.
 diameter : 1-4 mm
 length : 1000 mm



AMA 40-14T

Standards: AWS/ASME SFA - 5.18 ER70S-4

Application/ Properties: Low alloy wire electrode for TIG- Welding of general structural steels and pipe steels using Ar shielding gas.

Analysis of Wire electrode% (Typical value):

C	Si	Mn	P	S
0.07-0.15	0.65-0.85	1-1.5	≤0.025	≤0.025

Mechanical properties of all-weld metal using Ar shielding gas (single value are typical values) :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A4 (%)	Impact energy Joule ISO - V 25 °C
>420	500-640	>22	>80

Material:

Unalloyed Structural steels	DIN 17 100	St 33, St 37-2 to St 52-3 St 50*, ST 60*,St 50-2*, ST 60-2*
Pipe steels	DIN 1626/1629 DIN 1628/1630 DIN 17175 DIN 17172	St 37.0 to St 52.0 St 37.4 to St 52.4 St 35.8 to St 45.8, St 55*,St 55-4 StE 210.7 to StE 360.7
Fine grain structural steels	DIN 17 102 DIN1629	StE 255 to StE 355 WStE 255 to WStE 355 TStE 255 TO TStE 355
Boiler plates Shipbuilding steels casting steels	DIN 17 155	HI, HII, 17 Mn 4, 19Mn5* A, B, D, E GS-38, GS-45, GS-52
API Standards	API Standard	X42, X46

* Depending on plate thickness, preheat 150-300°C

Delivery: Welding rods, Copper coated:

weight :5 or 10 kg.

diameter : 1-4 mm

length : 1000 mm





AMA 40-16T

Standards: AWS/ASME SFA - 5.18 ER70S-6

Application/ Properties: Low alloy wire electrode for MAG- Welding of general structural steels and pipe steels using Ar shielding gas.

Analysis of Wire electrode% (Typical value):

C	Si	Mn	P	S
0.06-0.15	0.8-1.15	1.4-1.85	≤0.025	≤0.025

Mechanical properties of all-weld metal using Ar shielding gas (single value are typical values) :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A4 (%)	Impact energy Joule ISO - V -29 °C
>420	500-640	>22	>27

Material:

Unalloyed Structural steels	DIN 17 100	St 33, St 37-2 to St 52-3 St 50*, ST 60*;St 50-2*, ST 60-2*
Pipe steels	DIN 1626/1629 DIN 1628/1630 DIN 17175 DIN 17172	St 37.0 to St 52.0 St 37.4 to St 52.4 St 35.8 to St 45.8, St 55*,St 55-4 StE 210.7 to StE 360.7
Fine grain structural steels	DIN 17 102 DIN1629	StE 255 to StE 355 WStE 255 to WStE 355 TStE 255 TO TStE 355
Boiler plates Shipbuilding steels casting steels	DIN 17 155	HI, HII, 17 Mn 4, 19Mn5* A, B, D, E GS-38, GS-45, GS-52
API Standards	API Standard	X42, X46

* Depending on plate thickness, preheat 150-300°C

Delivery: Welding rods, Copper coated:

weight :5 or 10 kg.

diameter : 1-4 mm

length : 1000 mm





AMA 40-18T

Standards: DIN 8559 SG 2
 Material-No. 1.5125
 EN 440 G3 Si1

Application/ Properties: Low alloy wire electrode for MAG- Welding of general structural steels and pipe steels using **Ar shielding gas**.

Analysis of Wire electrode% (Typical value):

C	Si	Mn	P	S
0.06-0.12	0.7-1	>1.3-1.6	≤0.025	≤0.025

Mechanical properties of all-weld metal using Ar shielding gas (single value are typical values) :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact energy Joule ISO - V 25 °C
>420	500-640	>22	>80

Material:

Unalloyed Structural steels	DIN 17 100	St 33, St 37-2 to St 52-3 St 50*, ST 60*;St 50-2*, ST 60-2*
Pipe steels	DIN 1626/1629 DIN 1628/1630 DIN 17175 DIN 17172	St 37.0 to St 52.0 St 37.4 to St 52.4 St 35.8 to St 45.8, St 55*,St 55-4 StE 210.7 to StE 360.7
Fine grain structural steels	DIN 17 102 DIN1629	StE 255 to StE 355 WStE 255 to WStE 355 TStE 255 TO TStE 355
Boiler plates Shipbuilding steels casting steels	DIN 17 155	HI, HII, 17 Mn 4, 19Mn5* A, B, D, E GS-38, GS-45, GS-52
API Standards	API Standard	X42, X46

* Depending on plate thickness, preheat 150-300°C

Delivery: Welding rods, Copper coated:

weight :5 or 10 kg.

diameter : 1-4 mm

length : 1000 mm

