

# Lincoln® TIG S-6

## Key Features

- High levels of silicon and manganese for use on slightly contaminated base materials
- Good puddle fluidity
- Excellent wetting action, smooth bead appearance
- Stamp identification on each rod

## Typical Applications

- Repairs on a variety of mild and low alloy steel
- Small diameter pipe and tubing
- Sheet metal applications
- Root pass pipe welding

## Conformances

**AWS A5.18/A5.18M:** ER70S-6

## Welding Positions



## Shielding Gas

- 100% Argon
- Flow rate 10-15 L/min

## Diameter / Packaging / Settings

Diameter mm	Length mm	Part Number	Packaging
1.6	1000	604116	PE Tube 5kg
2.4	1000	604124	PE Tube 5kg

## Mechanical Properties - As required per AWS A5.18

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C
<b>Requirements</b> - AWS ER70S-6	400 min	480 min	22 min	27 min
<b>Typical Results</b> - As Welded	460	550	30	160

## Wire Composition

	%C	%Mn	%Si	%S	%P	%Cu
<b>Typical Results</b>	0.07	1.48	0.83	0.015	0.015	0.12