

Lincoln® ER70S-2

Mild Steel Cut Length • AWS ER70S-2

Conformances

AWS A5.18/A5.18M: 2005 ER70S-2
 ASME SFA-A5.18: ER70S-2

Welding Positions

All

Key Features

- ▶ Contains zirconium, titanium, and aluminum in addition to silicon and manganese
- ▶ Produces x-ray quality welds over most surface conditions
- ▶ Recommended for TIG welding on all grades of steel
- ▶ Ink jet printing identification on entire length of electrode
- ▶ Q2 Lot® - Certificates showing actual wire chemistry available online

Typical Applications

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

DIAMETERS / PACKAGING

Diameter in (mm)	5 lb (2.3 kg) Plastic Tube 20 lb (9.1 kg) Master Carton	10 lb (4.5 kg) Plastic Tube 30 lb (13.6 kg) Master Carton	50 lb (22.7 kg) Carton
1/16 (1.6)	ED034325	ED034328	ED034331
3/32 (2.4)	ED034326	ED034329	ED034332
1/8 (3.2)	ED034327	ED034330	ED034333

WIRE COMPOSITION – As Required per AWS A5.18/A5.18M: 2005

	%C	%Mn	%S	%Si	%P	%Cu	%Cr
Requirements - AWS ER70S-2	0.07 max.	0.90-1.40	0.035 max.	0.40-0.70	0.0025 max.	0.50 max.	(1)
Typical Results ⁽²⁾	0.04	1.08	0.005	0.55	0.0003	0.20	0.08
	%Ni	%Mo	%V	%Al	%Ti	%Zr	
Requirements - AWS ER70S-2	(1)	(1)	(1)	0.05-0.15	0.05-0.15	0.02-0.12	
Typical Results ⁽²⁾	0.08	0.08	< 0.002	0.08	0.10	0.07	

⁽¹⁾Total 0.50% maximum, combined. ⁽²⁾See test results disclaimer on pg. 18.