

# Lincoln® ER70S-2

## Key Features

- Triple deoxidised copper coated TIG rod. Contains zirconium, titanium, and aluminium in addition to silicon and manganese
- Produces x-ray quality welds over most surface conditions
- Ink jet printing identification on entire length of rod
- Q2 Lot – Certificates showing actual wire chemistry available online

## Conformances

**AWS A5.18/A5.18M:** ER70S-2

## Typical Applications

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

## Welding Positions



## Shielding Gas

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

## Diameter / Packaging / Settings

Diameter mm	Length mm	Part Number	Packaging
2.4	915	ED033953	PE Tube 4.5kg
3.2	915	ED033954	PE Tube 4.5kg

## 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-2	400 min	480 min	22 min	27 min
<b>Typical Results</b> - As Welded	530	610	31	80

## Wire Composition

	%C	%Mn	%S	%Si	%P	%Cu	%Cr
<b>Typical Results</b>	0.05	1.14	0.003	0.6	0.005	0.16	0.05
	%Ni	%Mo	%V	%Al	%Ti	%Zr	
<b>Typical Results</b>	0.04	0.02	<0.01	0.08	0.10	0.06	