



Signed by Mats Linde	Approved by M Bergenstråhle/Christos Skodras	Reg no EN004593	Cancelling EN003256	Reg date 2008-10-22	Page 1 (2)
-------------------------	---	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

EN 1668 is replaced by EN ISO 636-A

GENERAL

A tripple desoxidized copper coated rod designed for GTAW of mild and fine grained structural- and pressure vessel steels as well as ship building steels. The rod is capable of producing high quality welds in semi-killed and rimmed steel as well as steel of various carbon levels. Because of added desoxidants, Al-Ti-Zr, the rod can also be used for welding steels with a rusty or dirty surface, without any sacrifice of weld quality.

Shielding Gas: Argon

Alloy Type: Carbon-manganese steel

CLASSIFICATIONS Weld Metal

EN ISO 636-A W 46 4 W2Ti

APPROVALS

Not applicable

CLASSIFICATIONS Wire Electrode

EN ISO 636-A W2Ti
SFA/AWS A5.18 ER70S-2

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Ar			
C	0.05	0.04	0.07
Si	0.72	0.40	0.70
Mn	1.11	0.90	1.40
P	0.013		0.025
S	0.012		0.025
Cr			0.15
Ni			0.15
Mo			0.15
V			0.03
Cu			0.35
Al		0.05	0.15
Ti		0.05	0.15
Zr		0.02	0.12
Ti+Zr		0.07	0.25



Signed by Mats Linde	Approved by M Bergenstråhle/Christos Skodras	Reg no EN004593	Cancelling EN003256	Reg date 2008-10-22	Page 2 (2)
-------------------------	---	--------------------	------------------------	------------------------	---------------

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			Ar (I1) AWS
	Ar (I1) EN			
	As welded			
	Min	Max	Typ	
Rp0.2 (MPa)	460		570	400
Rm (MPa)	530	680	625	480
A4 (%)				22
A5 (%)	20		26	
Charpy V at -29°C (J)				27
Charpy V at -40°C (J)	47		180	