

GTAW

N065G

FAMILIARC™

TIG welding rod and wire

Features: ▪ Suitable for root pass welding of pipes
Classification: AWS A5.18 ER70S-2
Shielding Gas: Ar
Identification color: 1st Blue white
Polarity: DCEN

Packaging data

| φ mm | Spool | | Tube | | |
|------------------|------------------|------------------|-----------------|-----------|---------|
| | kg | | kg | Length mm | g/piece |
| 0.9 | 10 | - | - | - | - |
| 1.0 | 10 | - | - | - | - |
| 1.2 | - | - | 5 | 1,000 | 9 |
| 1.6 | - | 20 | 5 | 1,000 | 16 |
| 2.0 | - | - | 5 | 1,000 | 25 |
| 2.4 | - | - | 5 | 1,000 | 35 |
| 3.2 | - | - | 5 | 1,000 | 63 |
| Volume mm | 240W, 110H, 230L | 280W, 110H, 270L | 40W, 35H, 1015L | | |

Composition (wire mass%)

| | Typical | Guaranty ^a |
|-----------|---------|-----------------------|
| C | 0.04 | 0.07 |
| Si | 0.54 | 0.40~0.70 |
| Mn | 1.25 | 0.90~1.40 |
| P | 0.007 | 0.025 |
| S | 0.014 | 0.035 |
| Ni | 0.04 | 0.15 |
| Cr | 0.05 | 0.15 |
| Mo | 0.01 | 0.15 |
| Cu | 0.16 | 0.50 |
| V | <0.01 | 0.03 |
| Al | 0.07 | 0.05~0.15 |
| Ti | 0.08 | 0.05~0.15 |
| Zr | 0.05 | 0.02~0.12 |

Note: ^a Single values are maximum.

All-weld mechanical properties

| | Typical | | Guaranty |
|---------------------|---------|-------|----------|
| 0.2%YS (MPa) | 560 | 520 | 400min. |
| TS (MPa) | 620 | 600 | 483min. |
| El on 4d (%) | 28 | 30 | 22min. |
| IV -29°C (J) | 200 | 160 | 27min. |
| PWHT (°C×h) | AW | 625x8 | AW |