



Product Data Sheet

W'Tungsten inert gas arc welding'

Weld T W4Si1

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REASON FOR ISSUE

New product.

A copper coated, W4Si1/ER70S-6 rod for GTAW of general structural and engineering unalloyed and low alloyed carbon-manganese steels. It has a slightly higher silicon and manganese content, which increases the weld metal strength. The high silicon content promotes low sensitivity to surface impurities and contributes to smooth, sound welds.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Carbon-manganese steel

CLASSIFICATIONS Wire Electrode

EN ISO 636-A W 46 5 4Si1

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EN ISO 636-A W 4Si1
SFA/AWS A5.18 ER70S-6

Approvals

Not applicable

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C	0.06	0.14
Si	0.80	1.15
Mn	1.60	1.85
P		0.025
S		0.025
Cr		0.15
Ni		0.15
Mo		0.15
V		0.03
Cu		0.35

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Standard	Condition	ReL MPa		Rm MPa			A5 %		Charpy V J/-50°C	
		Min	Typ	Min	Max	Typ	Min	Typ	Min	Typ
EN	As Weld Ar(I1)	460	480	530	680	560	22	28	47	110