

TGA-56

AWS A5.18 ER70S-6
EN ISO 636-A-W 42 3 3Si1 H5
JIS Z3316 W 49 AP 3U 6

Characteristics and Applications

TGA-56 is designed for welding of mild steel and 490N/mm² grade steel. The product is often applied to butt or fillet welding of high pressure piping for shipbuilding, petro chemistry and nuclear power plant, etc. As an all-position welding rod for TIG welding, it is especially suitable for the root pass of pipe welding. Use DC(-) polarity.

Notes on usage

1. 100% Argon shielding gas with 99.997% high purity is recommended and the flow rate must be properly controlled. The flow rate is recommended 7-12l/min when arc current is 100-200Amp and it goes up to 12-15l/min when arc current rises to 200-300Amp.
2. Select right gas cup size and employ proper stick out of tungsten electrode.
3. To obtain a very clean weld pool, keep the weld plate free from dirt, rust, paint and any other atmospheric contamination.
4. Trailer Shield is required to ensure the weld pool completely shielded until solidification is complete and no porosity problem.

Typical chemical composition of wire (wt%):

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu
0.07	1.50	0.80	0.015	0.011	0.008	0.022	0.01	0.01	0.03

Typical mechanical properties of all weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-1bf) -30°C (-20)
485(70)	570(83)	32	300(221)

Sizes available:

Diameter (mm)	1.6	2.0	2.4	3.2
Length (mm)	915			

SOLID W

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welded electrode in accordance with AWS classification. Characteristics and procedures may vary for different results
obtained. This recommendation for any welding and the correct technique is controlled by TienTai Electrode Co., Ltd.

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No data is in the b