

Standards

TS EN ISO 14341-A	: G2Ti
TS EN ISO 636-A	: W2Ti
EN ISO 14341-A	: G2Ti
EN ISO 636-A	: W2Ti
AWS A5.18	: ER 70 S-2

Chemical Composition of Welding Wire % (Typical)

C	Mn	Si	Zr	Ti	Al
0.05	1.1	0.55	0.07	0.12	0.11

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-30°C)	Elongation ((L ₀ =5d ₀) (%))
min. 400	min. 480	min. 47 J	min. 22

Typical Base Material Grades

- S235J2G3-S355J2G3, P235T2-P355T2, L210NB-L290NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH P355GH, S235JRS1-S235J4S, S315G1S-S355G3S, P255NH-P355NH, S255N-S420N, GE200-GE300

Features and Applications

- Wire for welding mild and low alloy steels as well as thin walled materials
- Being triple deoxidized with Aluminium, Titanium and Zirconium as well as Manganese and Silicon, the wire is capable of producing efficient welds when the steel to be welded is rusty, dirty, undercoat painted
- It is recommended for pipe welding and for root passes in heavy vessel construction
- Also for welding of steels of which surface will be coated (such as galvanized, etc.)
- Shielding gases: MAG; Ar + CO₂ mix gases, TIG; %100 Ar gas can be used

Welding Positions



Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010202833	3010202856	0.8	0.030"	15	D 200
3010202835	3010202858	1.0	0.040"	15	D 100
3010202837	3010202860	1.2	0.047"	15	ECO PACK
3010202838	3010202862	1.6	0.062"	15	BIG PACK
		(0,6,0,9,1,14,1,4)		(1,5,15,18,50,250,400)	
	3010300222	1,60 x 1000	1/16 x 39"	5	Carton Box
	3010300223	2,00 x 1000	5/64 x 39"	5	
	3010300224	2,40 x 1000	3/32 x 39"	5	
	3010300225	3,20 x 1000	1/8 x 39"	5	
	3010300226	4,00 x 1000	5/32 x 39"	5	
	3010300227	5,00 x 1000	3/16 x 39"	5	

Approvals: SG 70 S2 · TSE, CE, SEPRO