

GTAW Solid Wire for High Tensile Strength Steel

TG-56

Classification

AWS	A5.18/A5.18M	ER70S-6/ER48S-6
JIS	Z3312	YGT50
EN	636-A	W423 W3Si1
GB	T 8110	ER50-6

Shielding Gas: Ar

Applications and Features

- (1) TG-56 is suitable for welding mild steel and 490N/mm² grade steel in butt joint/ H-fillet welding of high pressure pipe for ship-building, petro-chemistry and power plants.
- (2) Ideal for GTAW with Argon in the root pass of butt joints.

Welding Instruction

Please refer to Appendix C.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S
0.050	0.83	1.26	0.015	0.012

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %	Charpy V-Notch °C	J (kgf -m)
560(57.1)	470(48.0)	31	0	190(19.4)
			-30	170(17.3)

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6	2.0	2.4	2.6	3.2	4.0	4.8	5.0
Length (mm)	1000									