

TG-50

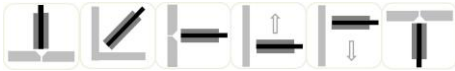
Classification

AWS A 5.18/A5.18M	ER70S-G/ER49S-G
JIS Z3316	W49A30
EN ISO 636-A	W 42 3 W0
GB T8110	ER50-G

Shielding Gas:100% Ar

Applications and Features

- (1) TG-50 is suitable for welding 490N/mm² grade steel.
- (2) TG-50 is an all-position welding rod for TIG welding. Especially suitable for root pass of pipe welding.
- (3) Ideal for welding pipeline in shipbuilding, petrochemical plants, power plants, and other high-pressure equipment applications.

Welding Position**Welding Instruction**

Please refer to Appendix C.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S
0.07	0.86	1.53	0.010	0.006

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
577	430	30	0	189
			-30	168

Size and Polarity (DC-)

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