

GTAW Solid Wire for High Tensile Strength Steel

TG-53

Classification

AWS A 5.18/A5.18M

JIS Z3316

EN ISO 636-A

GB T8110

ER70S-3/ ER49S-3

W49A33

W 42 3 W2Si

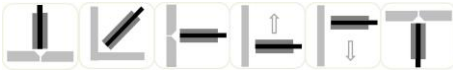
ER50-3

Shielding Gas:100% Ar

Applications and Features

- (1) TG-53 is suitable for welding 490N/mm² grade steel.
- (2) TG-53 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 industries, and nuclear power plants.

Welding Position



Welding Instruction

Please refer to Appendix C.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S
0.06	0.64	1.21	0.017	0.013

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
610	510	31	0	226
			-30	196

Size and Polarity (DC-)

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