

GTAW Solid Wire for High Tensile Strength Steel

TG-56

Classification

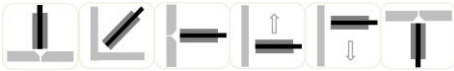
| | |
|-------------------|-----------------|
| AWS A 5.18/A5.18M | ER70S-6/ER49S-6 |
| JIS Z3316 | W49A36 |
| EN ISO 636-A | W 42 3 W3Si1 |
| GB T8110 | ER50-6 |

Shielding Gas:100% Ar

Applications and Features

- (1) TG-56 is suitable for welding 490N/mm² grade steel.
- (2) TG-56 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 |
|------|------|------|-------|-------|
| 0.05 | 0.83 | 1.46 | 0.012 | 0.012 |

Typical Mechanical Properties of Weld Metal

| Tensile Strength | Yield Strength | Elongation | Charpy V-Notch | |
|-------------------|-------------------|------------|----------------|-----|
| N/mm ² | N/mm ² | % | °C | J |
| 560 | 470 | 31 | 0 | 190 |
| | | | -30 | 170 |

Size and Polarity (DC-)

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