COMWELD LW1-6

- Copper Coated, Low Carbon Steel Rod for Gas TIG & Oxy Welding Applications.
- End stamped with "ER70S-6" for easy I.D.
- Recommended for the TIG welding of steel pipes, plates and castings with a tensile strength in the 500 MPa class.

Classifications:

AS/NZS 1167.2:	R6
AWS/ASME-SFA A5.2:	ER70S-4

Typical Weld Deposit Properties:

Yield Stress	400 MPa
Tensile Strength	500 MPa
Elongation	29%
CVN Impact Values	100J av@-20˚C

Typical Rod Analysis:

C: 0.08%	Mn: 1.16%	Si: 0.75%
S:0.010%	P: 0.015%	Fe: Balance

Joining process:
Gas (fusion) and Gas Tungsten Arc (TIG) welding

Comparable CIGWELD Products:
Autocraft LW1-6 GMAW wire
AWS A5.18: ER70S-4

Packaging Data:

Rod Size mm	Pack Weight/Type	Approx Rods/kg	Part No.
1.6 x 915	5kg pack	70	321417
2.4 x 915	5kg pack	31	321418

COMWELD Super Steel

- Low Carbon Steel Filler Rod for Gas Tungsten Arc (TIG) Welding.
- Triple Deoxidised for Superior Weld Deposit Quality and Resistance to Porosity.
- End Stamped with AWS Class ER70S-2.
- Ideal for TIG welding rusty or mill scaled plates and pipes and the root pass welding of pipes, tanks and heavy walled joints.

Classifications:

AS/NZS 1167.2:	R2
AWS/ASME-SFA A5.2:	ER70S-2

Typical Weld Deposit Properties:

Yield Stress	425 MPa
Tensile Strength	520 MPa
Elongation	34%
CVN Impact Values	150J av@-29˚C

Typical Rod Analysis:

C: 0.06%	Mn: 1.08%	Si: 0.52%
Ti: 0.08%	Zr: 0.07%	Al: 0.08%
S:0.007%	P: 0.008%	Fe: Balance

Joining process:
Gas Tungsten Arc (TIG) welding

Comparable CIGWELD Products:
Autocraft Super Steel GMAW wire
AWS A5.18: ER70S-2

Packaging Data:

Rod Size mm	Pack Weight/Type	Approx Rods/kg	Part No.
1.6 x 915	5kg tube	70	321370
2.4 x 915	5kg tube	31	321373

COMWELD CrMo1

- Nominal 1 1/4Cr 1/2Mo steel TIG rod.
- End Stamped with AWS Class ER80S-B2 for Easy Identification.
- For the Gas Tungsten Arc (TIG) Welding of matching Cr - Mo Creep Resistant Steels for Elevated Temperature and Corrosive Service.

Classifications:

AS/NZS 1167.2:	RB2
AWS/ASME-SFA A5.28:	ER80S-B2

Typical All Weld Metal Mechanical Properties:
Welding Grade Argon:

0.2% Proof Stress	500 MPa
Tensile Strength	600 MPa
Elongation (in 2 inches)	20%
CVN Impact Values	60J av @+ 20˚C

Post weld heat treated at 620˚C as required by AWS A5.28

Typical Rod Analysis:

C: 0.09%	Mn: 0.60%	Si: 0.60%
Cr: 1.30%	Mo: 0.50%	P: 0.015%
S:0.010%	Fe: Balance	

Comparable CIGWELD Products:
Alloycraft 80-B2 electrode
AWS A5.5: E8018-B2

Autocraft CrMo1 GMAW wire
AWS A5.28: ER80S-B2

Packaging Data:

Rod Size mm	Pack Weight/Type	Approx Rods/kg	Part No.
2.4 x 915	5kg tube	31	321379