



Elgatic 115

GTAW - TIG
Un-alloyed

Date:	2009-04-23
Revision:	9

Description:

Elgatic 115 is a triple deoxidised (silicon, manganese, aluminium) copper-coated TIG welding wire. It is recommended for high quality pipe welding of mild and medium tensile steels and is ideal for root passes in thick walled material.

Welding current:

DC-

Wire composition, wt.%

	C	Si	Mn	P	S	Cu	Al
Min		0,5	1,0				0,05
Typical	0,05	0,6	1,2	0,010	0,010	0,05	0,10
Max	0,07	0,7	1,4	0,025	0,025	0,35	0,15

	Ti	Zr
Min	0,05	0,02
Typical	0,10	0,07
Max	0,15	0,12

Shielding gas:

I1, Argon, 7-10 l/min

Stamping

F ER70S-2

Chemical composition, wt.%

	C	Si	Mn	P	S
Min					
Typical	0,05	0,5	1,1	0,01	0,01
Max					

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 420 MPa	460 MPa
Tensile Strength, Rm:	≥ 500 MPa	540 MPa
Elongation, A5	≥ 22%	26%
Impact energy, CV:	-29°C • >27 J -20°C • >47 J	-20°C • 80 J

Classification:

EN ISO 636 W 42 2 W2Ti
AWS A5.18 ER70S-2

Approvals:

TÜV
CE

Product data:

Ø x Length mm	Packet weight	Product code
1,6 x 1000	5 kg	95221016
2,0 x 1000	5 kg	95221020
2,4 x 1000	5 kg	95221024
3,0 x 1000	5 kg	95221030