

OK TIGROD S2

OK TIGROD S2 is a copper coated Mn-Si alloyed solid rod for TIG welding of non-alloyed steels, used in general construction, pressure vessel fabrication and shipbuilding. It is especially suitable for welding of light gauge non-alloyed steels in all positions and for a variety of applications, including root run for pipes & tubes.

Specifications

Classifications	EN ISO 636-A : W 46 3 W2Ti EN ISO 636-A : W2Ti SFA/AWS A5.18 : ER70S-2 IS 6419 : S1-I504
Approvals	BIS : S1-I504 CE : EN 13479 IBR : ER70S-2 PDIL : ER70S-2

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	C-Mn
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties

Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
As Welded	As welded	460 MPa	550 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-30 °C	120 J

Typical Wire Composition %

C	Mn	Si
0.05	1.10	0.55