

# ER 70S-A1 (A30)

Low Alloy WIRE/GTAW

## Standards

EN/ISO-Standard - 636-A  
EN/ISO-Classification - W 2Mo

AWS-Standard - A5.28  
AWS-Classification - ER 70S-A1

## Features and Applications

- A copper coated heat-resisting wire containing 0.5% molybdenum.
- Designed for welding low alloy creep resistant steels that require a high tensile strength.
- Weld deposit highly resistant to cold cracking.
- Recommended working temperatures of up to 500°C.
- Typically used on creep steels for construction steam boilers, pressure tanks, gas pipes, shipbuilding sector, petrochemical industry, heat exchangers, building of cranes, bridges etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



## Typical Base Materials

P295GH, P355GH, 16Mo3, 17Mo3, 14Mo6, S275, S355, S420, A210, A285, A335, A516, S275M, S355M, S420M, S460 15Mo3, 10MnMo45, 11MnMo45, GS60, GS22Mo4, 20MnMoNi5-5, 15NiCuMoNd5S, 17MnMoV64\*

\* Illustrative, not exhaustive list

## Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

## Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

## Polarity

DC (-)

## Mechanical Properties (Typical)

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
610	520	25	150	+20°C
			>47	-40°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

## Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % <sup>a</sup>	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti%
0.09	0.60	1.20	<0.015	<0.015	<0.25	<0.15	<0.10	0.50	<0.030	<0.020	<0.050

<sup>a</sup> (includes copper coating)

## Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
3010300421	1.60	1000	5	Cardboard Tube
3010300423	2.40	1000	5	Cardboard Tube
3010300424	3.20	1000	5	Cardboard Tube

**Liability:** Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.



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