

# TALARC S2

## CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.18: ER70S-2	EN ISO 14341-A: G 42 2 M G2Ti
	EN ISO 14341-A: G 38 2 C G2Ti

## ALLOY TYPE

Copper-coated solid wire for welding carbon and carbon-manganese steels.

## APPLICATIONS

Copper-coated solid wire designed for welding carbon and carbon-manganese steels with tensile strength up to 510 MPa. Suitable as well for welding thin, galvanised or electro-galvanised plates; with very limited spatter due to the addition of titanium and zirconium. The fusion allows the degassing of zinc vapours, which prevents the formation of blows and pores in the weld bead. To be used under the shield of Ar+CO<sub>2</sub> or CO<sub>2</sub>.

## TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cu %	Ti %	Zr %	Al %
0.06	1.10	0.50	0.012	0.012	0.15	0.10	0.09	0.10

## TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)			
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)
<b>MIX</b>	as welded	440	520	28	130	-	70	-

## WELDING GUIDELINES

Preheat and PWHT are not required.

## TECHNICAL INFORMATION

Gas: CO<sub>2</sub> & Mix Ar- CO<sub>2</sub> (EN ISO 14175)

Welding position: all positions



## WELDING PARAMETERS

Current	DC + Reverse polarity	
Diameter (mm)	0.9	1.2
Volts (V)	16 ÷ 30	18 ÷ 34
Current (A)	70 ÷ 230	100 ÷ 360

Diam.	15 kg Spool
0.9mm	INMS20915
1.2mm	INMS21215

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