

ST-50.6

AWS A5.18 / ASME SFA5.18 ER70S-6

Applications

Butt and fillet welding of carbon steel for pressure vessels, tubes for nuclear reactors, ships, penstock and aluminum-killed steel for low temperature service.

Characteristics on Usage

ST-50.6 is a wire for TIG welding with pure Ar gas.
All position welding and steel sheet welding can be performed quite easily.

Typical Chemical Composition of Wire (%)

C	Si	Mn	Shielding Gas
0.07	0.85	1.50	Ar

Typical Mechanical Properties of All-Weld Metal

YS MPa	TS MPa	EL (%)	CVN-Impact Value J @ -20°C
450	520	28	180

Typical Welding Conditions (DC-)

Size mm	Current A	Gas Flow (L/min.)	Shielding gas
1.6 ~ 3.2	100 ~ 200	25	Ar
2.4 ~ 3.2	200 ~ 300		
3.2	300 ~ 400		

Approval

ABS, CWB

Packing

Re-sealable tube 5 kg

Diam.	5 kg Tube
1.6mm	HKST-50-16
2.4mm	HKST-50-24
3.2mm	HKST-50-32

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