

ST-72

AWS A5.18 / ASME SFA5.18 ER70S-2

Applications

Butt and fillet welding of carbon steel for pressure vessels, tubes, ships.

Characteristics on Usage

- 1) Use welding grade Ar 100% gas.
- 2) All position welding and steel sheet welding can be performed quite easily.
- 3) Most suitable for one- side welding of tubes.

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Ti	Cu	V	Zr	Al
0.05	0.52	1.15	0.016	0.005	0.026	0.017	0.003	0.07	0.17	0.003	0.04	0.08

Typical Mechanical Properties of All-Weld Metal

YS MPa	TS MPa	EL (%)	CVN-Impact Value J @ -30°C
500	580	29.0	180

Typical Welding Conditions (DC-)

Size mm	Tungsten Electrode size (mm)	Current A	Gas Flow (L/min.)	Shielding gas
1.6 ~ 3.2	2.4	100 ~ 200	25	Ar
2.4 ~ 3.2	3.2	200 ~ 300		
3.2	4.0	300 ~ 400		

Packing

Re-sealable tube 5 kg

Diam.	5 kg Tube
1.6mm	HKST-72-16
2.4mm	HKST-72-24

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