

ST-50G

Mild Steel & 490 MPa high tensile steels

Conformances

AWS A5.18/ ASME SFA5.18 ER70S-G
JIS Z3316 YGT50
EN ISO 636-A-W3Si1
KR 3YSG
ABS AWS A5.18 ER70S-G (-50°C)
LR 3YH15
BV UP(-20°C)
DNV-GL IIIYMS
NK KSW53G
CCS 3YS

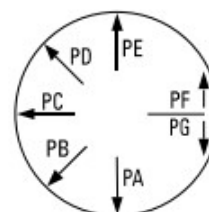
Applications

- Pressure vessels
- Nuclear reactors
- Rail road car
- Shipbuilding
- Pipeline

Features

- Good impact value at low temperature
- Good workability and Bead Appearance
- Good performance

Welding Position



Current

DC -

Shielding Gas

Ar

Diameter / Packaging

Diameter mm (in)	PVC TUVE 5kg (11lbs)
1.2 (0.045)	✓
1.6 (1/16)	✓
2.0 (5/64)	✓
2.4 (3/32)	✓
3.2 (1/8)	✓

Typical Chemical Composition of the Wire(%)

C	Si	Mn		
0.07	0.83	1.43		

Typical Mechanical Properties of All-Weld Metal

	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
As welded with 100% Ar	460 (66,700)	530 (76,900)	27	-20 (-4)	170 (125)

Diam.	5 kg Tube
2.4mm	HKST-50G24

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