

# ST-70A1

Type : TIG

## Conformances

AWS A5.28/ ASME SFA5.28 ER70S-A1

## Applications

- Structural steels resistant to heat and to hot work creep

## Features

- Good impact strength at low temperatures

## Welding Position

## Current

GTAW: DC-

## Shielding Gas

Ar

## Diameter / Packaging

Diameter	Length mm(in)
mm (in)	5kg (11lbs)
2.0 (5/64)	✓
2.4 (3/32)	✓
3.2 (1/8)	✓

## Typical Chemical Composition of the Wire (%)

C	Si	Mn	S	P	Cu	Ni
0.09	0.51	0.61	0.006	0.008	0.13	0.035
Cr	Mo	V	Ti	Al	Zr	Sn
2.390	0.94	0.003	0.002	0.004	0.003	0.001

## Typical Mechanical Properties of All-Weld Metal

YS Mpa(lbs/in <sup>2</sup> )	TS Mpa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)	PWHT
-	652 (94,500)	35.2	-25 (-13)	224 (165)	620°C × 1hr

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX