

ST-72

Mild Steel & 490 MPa high tensile steels

Conformances

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

JIS Z3316 YGT50

CWB ER48S-2 (ER70S-2)

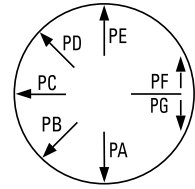
Applications

- Pressure vessels
- Shipbuilding

Features

- Good performance in all position
- One-side welding(tube)
- Ar 100% gas

Welding Position



Current

DC -

Shielding Gas

Ar

Diameter / Packaging

Diameter	PVC TUVE
mm (in)	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		
0.05	0.52	1.15		

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	500 (72,500)	580 (84,200)	29	-30 (-22)	180 (132)

SMW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX