

ST-50.6

Mild Steel & 490 MPa high tensile steels



Conformances

AWS A5.18/ ASME SFA5.18 ER70S-6
 JIS Z3316 YGT50
 EN ISO 636-A-W3Si1
 TÜV ISO 636-A-W42 5 W3Si1
 ABS AWS A5.18 ER70S-6(-30)
 CWB CSA W48 B-G 49A 3 C G6
 CE

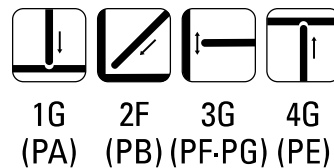
Applications

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

Features

- Good impact value at low temperature
- Good bead appearance
- Good performance

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		
0.07	0.85	1.5		

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	450 (65,300)	520 (75,500)	28	-20 (-4)	180 (132)

SAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX