

## MT-WSG 2

TIG-rod for welding mild and low-alloy steels. Suitable for working temperatures from -50°C up to +450°C.

### Standard designation

Material No.	1.5125
EN ISO 636-A	W 46 5 W3Si1
AWS/ASME SFA-5.18	ER 70 S-6

### Main base metals

S 185, S 235JRG2, S235S, 235J2G3, P265S, P235TR1, P235TR2, 265TR1, P265TR2, L210GA, P235GH, 195GH, L245MB, C21, L245NB, L245GA, P275N P280GH, L290MB, P295GH, L290NB, S355NL, P355N, P355NL1, S355J2G3

P245GH, GS 38, P265GH, C22.3, GS45, P215NL, P255QL, P265NL, P250GH, C22.8, S275JR, P275SL S275J2G3, S275NL, GP240GH, X42, P305GH, P355GH, S355N, L360MB, L360NB,

### Mechanical properties of all – weld – metal

(typical values)

Gas shield			I1 untreated +20°C	I1 untreated -50°C
Thermal treatment				
Test temperature		[°C]		
Yielding point	R <sub>eH</sub>	MPa	>420	
Tensile strength	R <sub>m</sub>	MPa	500-600	
Elongation	A <sub>5</sub>	[%]	>20	
Impact strength	A <sub>v</sub>	[J]	LNB	>47

### Average chemical composition of all-weld-metal (%)

C	Si	Mn
0,06-0,14	0,7-1,0	1,3-1,6

### Gas types available

I1

### Approvals

TÜV, DB, CE

### TIG rod diameters available, unit weights

Diameter [mm]	Length [mm]	kgs per box
1,00	1000	25,0
1,20	1000	25,0
1,60	1000	25,0
2,00	1000	25,0
2,40	1000	25,0
3,00	1000	25,0

Welding positions TIG acc.to EN ISO 6947

PA, PB, PC, PE, PF

Current/Polarity TIG

= -