

NST Carbotig 2F

AWS: A5-18: ER70S-6

EN ISO 636-A: W 46 5 W3Si1



TIG rod for welding unalloyed steels.

General description:

NST Carbotig 2F is a copper coated TIG wire rod for welding unalloyed steels with pure argon shielding gas.

Welding positions:



Current:

DC-

Gas flow:

12-20 l/min.

Chemical composition of welding rod:

C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V	Al	Ti+Zr		
0,06-0,14	1,40-1,60	0,80-1,00	Max 0.025	Max 0.025	Max 0.35	Max 0.15	Max 0.15	Max 0.15	Max 0.03	Max 0.02	Max 0.15		

Type of gas:

Argon

Mechanical properties of all-weld-metal:

Yield and Tensile Strength			Charpy Impact Test	
Yield Mpa	Tensile Mpa(Rm)	Elongation %	Charpy V (J) -50 °C	
≥460	530-680	Min. 22	≥47	

Packaging information:

1,6mm x 1000mm x 2,5Kg
2,0mm x 1000mm x 2,5Kg
2,4mm x 1000mm x 2,5Kg
3,2mm x 1000mm x 2,5Kg

Approvals:

CE

Reference / date:

NST Carbotig 2F,
English, 15.02.2016.

Perfect Welding

www.nst.no