

# 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)

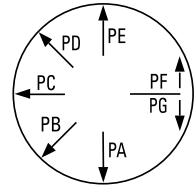
## Applications

- 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 <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	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)

SWAW

SAW

GM/AW

GTAW

FCAW

Non-FERROUS

APPENDIX