

ST-72

Mild Steel & 490 Mpa high tensile steels

Conformances

AWS A5.18 / ASME SFA5.18 ER70S-2
JIS Z3316 YGT50

Applications

- Pressure vessels
- Shipbuilding

Features

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

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF-PG) (PE)

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)

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX