

## GENERAL DESCRIPTION

Elite 871 Tig Rod is a deoxidised copper coated wire suitable for single pass or multi-pass welding of unalloyed and low alloyed steels and produces welds with excellent x-ray qualities with excellent mechanical resistance to low temperatures.

Under correct conditions this wire will provide less than 4 ml of hydrogen per 100g of weld metal.

Elite 871 Tig Rods (ER70S-6) are also known as PZ6500 by some manufactures.

### APPLICATIONS:

- Metal working industry
- General engineering
- Industrial machinery construction
- Pipes fabrication
- Boilers
- Low alloyed steels

## WELDING POSITIONS



## CLASSIFICATION

AS/NZS 1167.2 R6

AWS/ASME-SFA - 5.18 ER70S-6

## RECOMMENDED SHIELDING GASES

100% Argon

## CHEMICAL COMPOSITION

| Wt% - wire | C    | MN   | Si   |
|------------|------|------|------|
|            | 0.07 | 1.45 | 0.85 |

## TYPICAL MECHANICAL PROPERTIES

### Typical as welded

|                   |         |
|-------------------|---------|
| Yield Strength    | 450 MPa |
| Tensile strength  | 550 MPa |
| Elongation        | 24%     |
| CVN Impact Values | 80J@-40 |

## WELDING CURRENT

DC -

Welding parameters are a guide only as they are dependent on the machine used, material thickness and operator experience.  
No data is to be construed as a recommendation for any welding condition or technique by Euromarc.

## CONFORMANCE AND APPROVAL

CE

## STORAGE

Store all TIG filler rods in their original packaging in a controlled environment of less than 50% relative humidity.

#### WARNING

Electric shock can kill. Arc rays can injure eyes. Welding fumes are hazardous to your health and may damage lungs and other organs. Use adequate ventilation. Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection.

Read and understand the Safety Data Sheet for this product.

#### PACKAGING INFORMATION

| Size  | Weight | Length | Part Number / Order code |
|-------|--------|--------|--------------------------|
| 1.6mm | 5kg    | 1000mm | VR87116105               |
| 2.4mm | 5kg    | 1000mm | VR87124105               |

All rods are embossed for ease of identification.