

Inweld

Alloy ER70S-3

AWS A5.18

UNS Number: K11022



Description and Applications:

ER70S-3 is intended for welding single-pass and multi-pass welds. It provides sufficient deoxidation to allow welding over light mill scale. Typical base metal specifications are often the same as those for ER70S-2.

Chemical Composition of ER70S-3

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu	Ti	Zr	Al
0.06-0.15	0.90-1.40	0.45-0.75	0.025	0.035	0.15	0.15	0.15	0.03	0.50	-	-	-

Single values are maximum unless otherwise specified.

(As Welded)

Shielding Gas:	CO ₂
Tensile Strength (min)	psi: 70,000 MPa: 480
Yield Strength (min)	psi: 58,000 MPa: 400
Elongation % (min)	22

