# NO65G FAMILIARC™

**TIG welding rod and wire**

**Features:** ▪ Suitable for root pass welding of pipes

**Classification:** AWS A5.18 ER70S-2

**Shielding Gas:** Ar

**Identification color:** 1st Blue white, 2nd -

**Polarity:** DCEN

## Packaging data

| | Spool | | Tube | | |
|---|---|---|---|---|---|
| **ϕ mm** | **kg** | | **kg** | **Length mm** | **g/piece** |
| 0.9 | 10 | - | - | - | - |
| 1.0 | 10 | - | - | - | - |
| 1.2 | - | - | 5 | 1,000 | 9 |
| 1.6 | - | 20 | 5 | 1,000 | 16 |
| 2.0 | - | - | 5 | 1,000 | 25 |
| 2.4 | - | - | 5 | 1,000 | 35 |
| 3.2 | - | - | 5 | 1,000 | 63 |
| **Volume mm** | 240W, 110H, 230L | 280W, 110H, 270L | 40W, 35H, 1015L | | |

## Composition (wire mass%)

| | Typical | Guaranty [a] |
|---|---|---|
| **C** | 0.04 | 0.07 |
| **Si** | 0.54 | 0.40~0.70 |
| **Mn** | 1.25 | 0.90~1.40 |
| **P** | 0.007 | 0.025 |
| **S** | 0.014 | 0.035 |
| **Ni** | 0.04 | 0.15 |
| **Cr** | 0.05 | 0.15 |
| **Mo** | 0.01 | 0.15 |
| **Cu** | 0.16 | 0.50 |
| **V** | <0.01 | 0.03 |
| **Al** | 0.07 | 0.05~0.15 |
| **Ti** | 0.08 | 0.05~0.15 |
| **Zr** | 0.05 | 0.02~0.12 |

Note: [a] Single values are maximum.

## All-weld mechanical properties

| | Typical | | Guaranty |
|---|---|---|---|
| **0.2%YS (MPa)** | 560 | 520 | 400min. |
| **TS (MPa)** | 620 | 600 | 483min. |
| **El on 4d (%)** | 28 | 30 | 22min. |
| **IV -29℃ (J)** | 200 | 160 | 27min. |
| **PWHT (℃xh)** | AW | 625x8 | AW |