TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP 2Ti

MILD STEEL

CLASSIFICATIONS

EN ISO 14341-A	AWS A5.18
G 42 3 M21 2Ti	ER70S-2

KEY FEATURES AND APPLICATIONS

- Micro-alloyed steel wire that is triple deoxidized with the additions of titanium, aluminium and zirconium.
- Typically used on welding applications involving carbon-manganese and low-alloyed steels.
- The formulation allows for effective use on surfaces with residual grease or oxidation, such as galvanised steel before the coating process.
- Excellent mechanical properties at subfreezing temperatures down to -30°C.
- Widespread usage across diverse industries, including fabrication of tanks, containers, automotive components, structural assemblies, household appliances, pipelines, boilers, naval vessels and petrochemical infrastructures.

BASE MATERIALS

S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S420N, S275M-S420M, P235GHP355GH, P355N, P285NH-P355NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L245MB-L415MB, GE200-GE240

ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. A, C, E; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Ni	Cr	Mo	V	Cu	Al	Ti + Zr
MIN	0.04	0.40	0.90	-	-	-	-	-	-	-	0.05	0.05
MAX	0.14	0.80	1.40	0.025	0.025	0.15	0.15	0.15	0.03	0.35	0.20	0.25

Single values are maximum values according to EN ISO 14341

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
480 (≥420)	560 (500 - 640)	24 (≥20)	50 (≥47)	-30°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - M21	DC+

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP10278	0.8	BS300	15	72
XP10281	1.0	BS300	15	72
XP10284	1.2	BS300	15	72

MADE IN EU