

Ultramag®

TOP FEATURES

- Good performances in terms of feedability and weldability.
- Stable arc and low spatter.
- High productivity.

TYPICAL APPLICATIONS

- General Constructions
- Heavy Fabrication
- Infrastructures
- Automotive

CLASSIFICATION

AWS A5.18	ER70S-6
EN ISO 14341-A	G42 3 C1 3Si1 / G46 4 M20 3Si1 / G46 4 M21 3Si1

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO ₂
M20	Mixed gas Ar+ 5-15% CO ₂
C1	Active gas 100% CO ₂

APPROVALS

ABS	LR	DNV	TÜV	DB	CE
+	+	+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si
0.08	1.40	0.85

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical values	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-30 °C	-40 °C
	M21	AW	470	570	24		170
	C1	AW	450	550	25	71	130

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)
0.6	SPOOL (S200)	5.0
	SPOOL (S200)	5.0
0.8	SPOOL (B300)	16.0
	SPOOL (BS300)	16.0
	DRUM	250.0
0.9	DRUM	250.0
1.0	SPOOL (S200)	5.0
	SPOOL (B300)	16.0
	SPOOL (BS300)	16.0
	DRUM	250.0, 500.0
1.2	SPOOL (S200)	5.0
	SPOOL (B300)	16.0
	SPOOL (BS300)	16.0
	DRUM	250.0, 500.0
1.4	DRUM	500.0
1.6	SPOOL (B300)	16.0
	SPOOL (BS300)	16.0
	DRUM	250.0, 500.0

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.