

UltraMag® G4Si1

CLASSIFICATION

AWS A5.18	ER70S-6	A-Nr	1	Mat-Nr	1.5130
EN ISO 14341-A	G 46 5 M21 4Si1 / G 46 3 C1 4Si1	F-Nr	6		
		9606 FM	1		

GENERAL DESCRIPTION

Coppered solid wire for semi-automatic and automatic welding applications
Good feedability, consistent welding performance
Very good weldability, stable arc, and low spatter
High productivity

WELDING POSITIONS (ISO/ASME)



SHIELDING GASES (ACC. ISO 14175)

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

APPROVALS

ABS	BV	DNV/GL	DB	LRS	RINA	CE	TÜV
+	+	+	+	+	+	+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si
0.08	1.70	0.85

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						-40°C	-50°C
Typical values	M21	AW	490	590	27		90
	C1	AW	460	560	25	70	

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
General structural steels	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 to DH36
Cast steels	EN 10213-2	GP240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
Boiler & pressure vessel steels	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	EN 10025 part 3	S275, S355, S420, S460
	EN 10025 part 4	S275M, S275ML, S355M, S355ML, S420M, S420ML, S460, P460, S460ML

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2	1.6
16 Kg spool B300	X	X	X	X
15 kg spool S300	X	X	X	
250 kg Accutrak® Drum	X	X	X	
500 kg Accutrak® Drum	X	X	X	X

Other sizes and packaging on request



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