

# ULTRAFIL 1

## TOP FEATURES

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

## TYPICAL APPLICATIONS

- General fabrication
- Heavy Fabrication
- Automotive

## CLASSIFICATION

AWS A5.18	ER70S-6
EN ISO 14341-A	G 42 3 C1 3Si1
	G 42 4 M21 3Si1

## SHIELDING GASES (ACC. EN ISO 14175)

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

## APPROVALS

TÜV	DB	CE
+	+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S
0.08	1.4	0.9	≤0.025	≤0.025

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-20°C	-40°C
Typical values	M21	AW	480	560	29		150
	C1	AW	460	540	28	120	

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
0.8	SPOOL (BS300)	16.0	E08L016P6E11
	SPOOL (BS300)	16.0	E10L016P6E11
1.0	DRUM	300.0	E10D300E6E11
	SPOOL (BS300)	16.0	E12L016P6E11
1.2	DRUM	300.0	E12D300E6E11

## 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](http://www.lincolnelectric.eu) for any updated information.