

ULTRAFIL 1A

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 46 3 C1 4Si1
	G 46 4 M21 4Si1

SHIELDING GASES (ACC. EN ISO 14175)

C1	Active gas 100% CO ₂
M14	Mixed gas Ar+ 0.5-5% CO ₂ + 0.5-3% O ₂
M21	Mixed gas Ar+ 15-25% CO ₂

APPROVALS

TÜV	DB	CE
+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S
0.08	1.7	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	-30°C	-40°C
Typical values	M21	AW	≥460	530-680	≥24	≥100	≥80	≥70
	C1	AW	≥460	530-680	≥24	≥80	≥47	

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (B300)	16.0	E10K016P3E11
	SPOOL (B300)	16.0	E12K016P3E11
1.2	SPOOL (BS300)	16.0	E12L016P3E11

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.