

CLASSIFICATION

| | | | | | |
|----------------|----------------------------------|---------|---|--------|--------|
| AWS A5.18 | ER70S-6 | A-Nr | 1 | Mat-Nr | 1.5130 |
| EN ISO 14341-A | G 42 3 M21 3Si1 / G 38 2 C1 3Si1 | 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)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

SHIELDING GASES (ACC. ISO 14175)

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

APPROVALS

DB

+

TÜV

+

CE

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

| C | Mn | Si |
|------|------|------|
| 0.08 | 1.50 | 0.85 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | Condition | Yield strength | Tensile strength | Elongation | Impact ISO-V(J) |
|----------------|-----------|----------------------|----------------------|------------|-----------------|
| | | [N/mm ²] | [N/mm ²] | [%] | -30°C |
| Typical values | AW | 440 | 540 | 30 | 60 |

PACKAGING AND AVAILABLE SIZES

| Diameter (mm) | 0.8 | 1.0 | 1.2 |
|-------------------|-----|-----|-----|
| 15 kg spool S300 | X | X | X |
| 15 kg spool BS300 | X | X | X |
| 250 kg drum | | X | X |

Other sizes and packaging on request