

Supra MIG Ultra®

Mild steel solid wire

Classification

AWS A5.18/A5.18M-01 : ER70S-6

EN 440-94 : G 46 4 M G4Si1 / G 42 3 C G4Si1

General description

Solid GMAW wire with increased manganese for semi-automatic welding and robotic applications

Excellent feedability, very consistent welding performance

Very good weldability, tight and stable arc with extremely low spatter, low fume productions

Better bead profile and appearance

Highest productivity

Also available in AccuTrak®

Shielding gases (acc. EN 439)

GMAW	M21	Mixed gas Ar+ >5-25% CO ₂
	C1	Active gas 100% CO ₂

Approvals

	BV	DB	DNV	GL	TÜV
GMAW	S3Y40M	+	IVY40MS	4Y42S	+

Chemical composition (w%), typical, wire

C	Mn	Si
0.08	1.70	0.85

Mechanical properties, typical, all weld metal

Typical values	Process	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
							-20°C	-40°C
	GMAW	M21	AW	500	650	26	80	80

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 t/m DH36
Cast steel	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/ EN 10217-1	P235T1, P235T2, P275T1 P275T2, P355N
Boiler & pressure vessel steel	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steel	EN 10113-2	S275, S275, S355, S420
	EN 10113-3	S275M, S275ML, S355M, S355ML, S420M, S420ML, S460

Packaging

Process	Unit	Sizes (mm)		
		0.8	1.0	1.2
GMAW	15 kg spool B300	X	X	X
	250 kg AccuTrack	X	X	X

Other sizes and packaging on request

Supra MIG Ultra®: rev. EN 15

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