

## Mild steel solid wire

### Classification

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

EN 440-94 : G 42 4 M G3Si1 / G 38 3 C G3Si1

### General description

**Solid wire for welding of structural steels**

**Excellent feedability and very consistent welding performance**

**No adjustments of welding parameters**

**Tight and stable arc with extremely low spatter**

**Better bead profile and appearance**

**Ultimate GMAW wire for robotics and hard automation**

**Also available in AccuTrak®**

### Shielding gases (acc. EN 439)

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

### Approvals

	BV	DB	DNV	GL	LR	TÜV
GMAW	S3YM	+	IVY40	4Y40S	3S,3Y40S	+

### Chemical composition (w%), typical, wire

C	Mn	Si
0.08	1.55	0.85

### Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)		
							-30°C	-40°C	-50°C
Typical values	GMAW	M21	AW	490	590	27	100	60	40

### 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
Boiler & pressure vessel steel	API 5LX	X42, X46, X52, X60
	EN 10216-1/-3	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
	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

### Packaging

Process	Unit	Sizes (mm)			
		0.8	1.0	1.2	1.6
GMAW	15 kg spool B300	X	X	X	
GMAW	15 kg spool S300	X	X	X	X
	250 kg AccuTrack	X	X	X	

Other sizes and packaging on request