

WAAM solid wire, unalloyed, structural steel

Material Type				
S355	10Mn4	1.1108		
Characteristics				
WAAM solid wire designed for 3Dprinting of unalloyed steel structures. The printed deposit is characterised by a low Mn and Si content.				
Typical analysis of the solid wire (wt.-%)				
	C	Si	Mn	
wt.-%	0.10	0.3	1.05	
Available products				
Diameter: 1,0 mm – 1,2 mm Package: BS300 15 kg – ECOdrum 100 – ECOdrum 250 – S760 300 Other diameters and packages on request.				
Typical mechanical properties acc. to EN ISO 15792-1				
Heat treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation (L ₀ =5d ₀)	Impact energy ISO-V KV J
	MPa	MPa	%	-20 °C
u	420	500	25	75
u untreated, as welded – shielding gas Ar + 18 % CO ₂ , DC+				
Classification as welding consumable:				
EN ISO 14341-A		AWS A5.18		
G 35 2 M21 Z2Si		ER70S-G		