

WAAM solid wire, unalloyed, structural steel

Material Type		
S460	8MnSi7	1.5115

**Characteristics**  
 WAAM solid wire designed for 3Dprinting of cryogenic fine grained steel structures.  
 The printed deposit is characterised by good low temperature properties.

Typical analysis of the solid wire (wt.-%)			
	C	Si	Mn
wt.-%	0.1	1.00	1.7

**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.

**Approvals**  
 ABS (3YSA)

Typical mechanical properties acc. to EN ISO 15792-1					
Heat treatment	Yield strength Rp0.2	Tensile strength Rm	Elongation (L0=5d0)	Impact energy ISO-V KV J	
	MPa	MPa	%	-20 °C	-40 °C
u	480	580	24	60	47
u untreated, shielding gas Ar + 18 % CO <sub>2</sub> , DC+					

Classification as welding consumable:

EN ISO 14341-A	AWS A5.18
G 46 4 M21 4Si1 / G 46 2 C1 4Si1	ER70S-6