

WAAM solid wire, low-alloyed, high strength structural steel

Material Type	
S620	10MnNiMoSi6-4-4

Characteristics
WAAM solid wire designed for 3Dprinting of fine grained steel structures with high yield strength. Good low temperature toughness.

Typical analysis of the solid wire (wt.-%)					
	C	Si	Mn	Ni	Mo
wt.-%	0.10	0.65	1.55	1.10	0.40

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 of all-weld-metal EN ISO 15792-1			
Heat treatment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation ($L_0=5d_0$)
	MPa	MPa	%
u	620	700	18
u untreated, shielding gas Ar + 18 % CO ₂ , DC+			

Classification as welding consumable:

EN ISO 16834-A	AWS A5.28
G 62 5 M21 Mn3Ni1Mo	ER90S-G