



SELECTARC MIG F56

Old reference : MIG 70S3

Classification

AWS A5.18 : ER70S-3

Characteristics

GMAW wire to weld low alloyed standard construction / boiler steels. Solid wire with Silicon & Manganese levels is suitable for general purpose welding over clean to light level of Dust & mill Scale. MIG F56 has the flexibility to provide trouble free performance in heavy duty, high speed spray or pulse applicable to lighter duty, lower speed, short arc applications.

Applications

Ship building, Off-shore, Repair & Construction. Automotive structures, Form implements, Vessels, Pipe fabrication, Rail car Construction and Repair, General fabrication.

Typical Weld Metal Composition (%)

C	Si	Mn	Cu	P	S	Fe
0.07	0.65	1.10	0.20	0.015	0.016	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg A _s	Impact (KV)	
	R _m (MPa)	R _e (MPa)		Temp. °C	J
AW	560	460	26	+20	150
				-20	90
				-50	50

Welding Current & Instructions

Welding Mode	Wire Ø (mm)	Welding Mode		Shielding Gas ISO 14175
		(A)	(V)	
MIG	0.6	40 - 90	16 - 21	M21 (Ar/CO ₂) C1 (100% CO ₂) 12 - 15 l/min
	0.8	60 - 100	18 - 21	
= +	1.0	75 - 140	25 - 28	
	1.2	150 - 220	26 - 28	
	1.6	180 - 250	26 - 32	

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