

## Classification

AWS A5.18 : ER70S-6

ISO 14341-A : G3Si1

## Description & Applications

Copper coated solid wire for GMAW to weld low alloyed standard construction / boiler steels.

**Main applications:** For general metal constructions, in the automobile industry, blacksmithing, ship building etc.

**Base material:**

**Construction steels for general use , Tube steels, Ship steels**

EN- Designation	S185 – S355	L210 – L360
	P235 – P355	
Ship steels	Quality A and B	
ASTM	A285 grade C	A414 grade C, D, E, F
	A442 grade 55, 60	A515 grade 55, 60, 65

## Typical Chemical Composition ( % )

C	Si	Mn	Fe
0.07	0.85	1.45	Rem.

## All Weld Metal Mechanical Properties

R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )	
470	550	25	+20°C	150
			-30°C	80

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.6	40-90	16-21	EN 439: M21 (Ar/CO <sub>2</sub> ) C1 (100% CO <sub>2</sub> ) 12-15 l/min
	0.8	60-100	18-21	
	1.0	150-170	25-28	
	1.2	170-220	26-28	
	1.6	180-270	26-32	

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