

Classifications

AWS A5.18	EN ISO 636-A	GB/T8110
ER70S-3	W 2Si	ER50S-3

Characteristics and typical fields of application

- Very good weldability in out of position work; Excellent cold toughness at - 20°C.
- Large application range; especially suited for steels of higher strength in boiler and pipeline construction, shipbuilding, vehicle manufacturing and structural engineering.

Base materials

20g,20Cr steel.

Typical analysis of solid wire (wt.-%)

C	Si	Mn	P	S	Cr	Mo	Cu			
0.08	0.65	1.21	0.008	0.006	0.08	0.04	0.08			

Mechanical properties of all-weld metal – typical values (min. values)

Heat-treatment	R _{p0,2}	R _m	A ₄	K _v (J)	
	MPa	MPa	%	-20°C	-30°C
AW	450(≥420)	560(≥500)	32(≥ 22)	210(≥47)	100(≥47)

Operating data

	Polarity:	Size(mm)	Shielding gases:
	DC -	1.6x1000	ISO 14175,I
		2.0x1000	
		2.4x1000	

Approvals

CE