

## CLASSIFICATION

AWS A5.18	ER70S-6	A-Nr	1	Mat-Nr	1.5130
EN ISO 14341-A	G 42 3 M 3Si1 / G 42 3 C 3Si1	F-Nr	6		
		9606 FM	1		

## GENERAL DESCRIPTION

Coppered solid wire for semi-automatic and automatic welding applications

Good feedability, consistent welding performance

Very good weldability, stable arc, and low spatter

High productivity

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

## SHIELDING GASES (ACC. ISO 14175)

M21	Mixed gas Ar+ >15-25% CO <sub>2</sub>
C1	Active gas 100% CO <sub>2</sub>

## APPROVALS

DB

+

TÜV

+

CE

+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si
0.08	1.50	0.90

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation [%]	Impact ISO-V(J)	
					+20°C	-30°C
Typical values	AW	420	500-640	>24	>90	>47

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2
16 Kg spool B300	X	X	X
16 kg spool BS300	X	X	X

Other sizes and packaging on request