

CLASSIFICATION

AWS A5.18	ER70S-6	A-Nr	1	Mat-Nr	1.5130
EN ISO 14341-A	G42 4 M21 4Si1 / G42 3 C1 4Si1	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 ₂
C1	Active gas 100% CO ₂

APPROVALS

DB

+

TÜV

+

CE

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si
0.08	1.70	1.00

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength	Tensile strength	Elongation	Impact ISO-V(J)
		[N/mm ²]	[N/mm ²]	[%]	-30°C
Typical values	AW	470	570	25	60

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2
15 kg spool S300	X	X	X
15 kg spool BS300	X	X	X
250 kg drum		X	X

Other sizes and packaging on request