

Mild steel solid wire

Classification

AWS A5.18/A5.18M : ER70S-6
ISO 14341 : G 46 4 M G3Si1

General description

Solid wire for welding general construction in mild steel
Smooth bead appearance
Stable arc and excellent feedability

Shielding gases (acc. ISO 14175)

M21 Mixed gas Ar+ >5-25% CO₂
C1 Active gas 100% CO₂

Approvals

ABS	BV	DNV	GL	LR	RINA	TÜV	RMRS
3SA,3YSA	SA3YM	IIIYMS	3YS	3S,3YS	3YS	+	3S,3YS

Chemical composition (w%) typical wire / rod

C	Mn	Si
0.08	1.4	0.8

Mechanical properties, typical, all weld metal

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						-20°C	-40°C
Typical values	M21	AW	520	600	25	110	70

Materials to be welded

Steel grades	Code	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 to DH 36.
Cast steel	EN 10213-2	GP240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1/ EN 10217-1	P235T1, P235T2, P275T1 P275T2, P355N
Boiler & pressure vessel steel	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steel	EN 10113-2	S275, S275, S355, S420
	EN 10113-3	S275M, S275ML, S355M, S355ML, S420M, S420ML

Packaging and available sizes

Unit type	Diameter (mm)				
	0.6	0.8	1.0	1.2	1.6
5 kg plastic spool S200	X	X	X		
15 kg spool B300		X	X	X	X
15 kg spool S300	X				
250 kg Accutrak® Drum		X	X	X	
300 kg metal coil				X	
Other sizes and packaging on request					

LNM 26: rev. EN 22

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