

Standards

TS EN ISO 14341-A	: G 42 3 M21/C1 3Si1
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SFA/AWS A5.18	: ER 70 S-6

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	P	S	Cu
0,07	1,460	0,860	0,005	0,014	0,07
		Cr	Ni	Mo	
		0,06	0,05	0,012	

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation Lo=5do- (%)	Impact Strength (-30 oC) (J)
440	550	min. 28	70

Typical Base Material Grades

- E295, E335, S235J2G3, P235T1-P335T1, P235T2-P335T2, L210NB-L415NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, P255NH-P355NH, GE200-GE260

Features and Applications

- Steel construction and machinery production.
- Welding of ships, boiler tanks, pipe parts.
- Welding of thin walled steels.
- Thin sheet welding in automotive industry.
- Perfect smooth feedability, perfect welding characteristics.
- Shielding gases: For MAG welding, Ar + CO₂ gas mixtures are used; for TIG welding, 100% Ar gas can be used.

Welding Positions

Operating Data

Product Code	Diameter (mm)	Welding Current (A)	Weight (Kg)	Package Type
	0.80			
	1.00			
	1.20			
	1.60			