

Standards

TS EN ISO 14341-A	: G2Si
TS EN ISO 636-A	: W2Si
EN ISO 14341-A	: G2Si
EN ISO 636-A	: W2Si
AWS A5.18	: ER 70 S-3

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn
0.10	0.6	1.2

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-30°C)	Elongation ((L ₀ =5d ₀) (%))
min. 440	530	min. 91 J	min. 26

Typical Base Material Grades

- S235J2G3-S355J2G3, P235T2-P355T2, L210NB - L290NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH P355GH, S235JRS1-S235J4S, S315G1S-S355G3S, P255NH-P355NH, GE200-GE300

Features and Applications

- Welding of thin walled parts
- Root pass welding
- For making galvanized coating
- TIG welding of tubes and pipes
- Shielding gases: TIG: Ar / MAG: 20% CO₂, - 80% Ar or pure CO₂

Welding Positions



Current Type

TIG D.C.(-) / MAG D.C.(+)

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				BS/D/300
3010200009	3010200033	0.8	0.030"	15	D 200
3010200011	3010200035	1.0	0.040"	15	D 100
3010200013	3010200037	1.2	0.047"	15	ECO PACK
3010200014	3010200039	1.6	0.062"	15	BIG PACK
		(0,6,0,9, 1.14,1.4)		(1,5,15,18,50,250,400)	
3010300115		1,60 x 1000	1/16 x 39"	5	Carton Box
3010300116		2,00 x 1000	5/64 x 39"	5	
3010300117		2,40 x 1000	3/32 x 39"	5	
3010300118		3,20 x 1000	1/8 x 39"	5	
3010300119		4,00 x 1000	5/32 x 39"	5	
3010300120		5,00 x 1000	3/16 x 39"	5	