

### 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 <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-30°C)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))
min. 400	480 - 600	min. 47 J	min. 22

### 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% CO<sub>2</sub>, - 80% Ar or pure CO<sub>2</sub>

### Welding Positions



### Current Type

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

### Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
<b>BS 300</b>	<b>D 300</b>				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	