

Normalised designation : ISO 14341-A: G3Si1

AWS A5.18: ER70S-6

N° de Matériau : 1.5112

Properties:

Full wire for gas-protected welding of non-allied and weakly allied carbon steels.

Applications :

Automotive, rail, naval construction. Construction and maintenance of agricultural equipment, public works equipment, mines and quarries.

Weldable steels: General-purpose construction

EN- Désignation	S185 - S355	L210 - L360
	P235 - P355	
Tôles navales	Qualités A et B	
ASTM	A285 grade C	A414 grade C, D, E, F
	A442 grade 55, 60	A515 grade 55, 60, 65

Mechanical properties :

Re=470 MPa

Rm = 550 MPa

A5 = 25 %

KV > 150 J à + 20 °C / > 80 J à - 30 °C

Employment parameters and conditions: MIG - Continuous

Gaz (ISO 14175)	Ø (mm)	Paramètres de soudage	
		Arc pulsé (A)	(V)
M21 (Ar/CO ₂) C1 (100% CO ₂) 12 - 15 L/min	0,8	60 - 100	18 - 21
	1	150 - 170	25 - 28
	1,2	170 - 220	26 - 28
	1,6	180 - 270	26 - 32

Packaging : coil 15 kg

Responsibility: The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request