

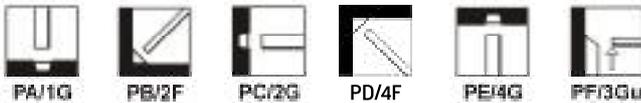
### CLASSIFICATION

AWS A5.18	ER70S-6	A-Nr	1	Mat-Nr	1.5130
EN ISO 14341-A	G 42 3 M21 3Si1 / G 38 2 C1 3Si1	F-Nr	6		
		9606 FM	1		

### GENERAL DESCRIPTION

Coppered solid wire for semi-automatic and automatic welding applications  
 Good feedability, consistent welding performance  
 Very good weldability, stable arc, and low spatter  
 High productivity

### WELDING POSITIONS (ISO/ASME)



### SHIELDING GASES (ACC. ISO 14175)

M21	Mixed gas Ar+ >15-25% CO <sub>2</sub>
C1	Active gas 100% CO <sub>2</sub>

### APPROVALS

DB	TÜV	CE
+	+	+

### CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si
0.08	1.50	0.85

### MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) -30°C
Typical values	AW	440	540	30	60

### PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2
15 kg spool S300	X	X	X
15 kg spool BS300	X	X	X
250 kg drum		X	X

Other sizes and packaging on request