

Mild steel solid wire

Classification

AWS A5.18/A5.18M	:ER70S-6
EN ISO 14341	:G4Si1

General Description

Solid GMAW wire for automatic and machine welding
Excellent feedability, very consistent welding performance
Good weldability, stable arc, low spatter
Highest productivity

Shielding gases (acc. EN 439)

GMAW	M21	Mixed gas Ar+ >5-25% CO ₂
	C1	Active gas 100% CO ₂

Approvals

	DB	RS	TÜV
GMAW	+	+	+

Chemical composition (% by mass), typical, all-weld metal

C	Mn	Si
0.07	1.65	0.90

Mechanical properties, all-weld metal

	Process	Shielding gas	Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)		Impact (ISO), J	
						-40°C	-50°C		
Typical values after welding	GMAW	M21	AW	478	595	27			89
		C1		462	558	30	73		
		required		min 420	500-640	min 22	min 47		

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 to DH36
Cast steel	EN10213-2	GP240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1/	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
Boiler & pressure vessel steel	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steel	EN 10113-2	S275, S275, S355, S420
	EN 10113-3	S275M, S275ML, S355M, S355ML, S420M, S420ML, S460

Packaging, available sizes and identification

Process	Unit:	Sizes, mm				
		0.8	1.0	1.2	1.4	1.6
GMAW	15 kg spool K300	X	X	X	X	X
GMAW	15 kg spool B300-D300	X	X	X	X	X
GMAW	250 kg WUTPACK®Eco	X	X	X		
GMAW	380 kg WUTPACK®Eco	X	X	X	X	X
GMAW	500 kg WUTPACK®Eco	X	X	X	X	X

Other sizes and packaging on request

Identification

Imprint: Revix®SG 3

Tip colour:

Revix® SG 3: rev.EN 20