

Mild steel solid wire

Classification

AWS A5.18/A5.18M :ER70S-6
EN 440 :G 42 3 M G4Si1

General Description

Solid wire with increased manganese content for GMA welding of structural steel

Shielding gases (acc. EN 439)

GMAW M21 Mixed gas Ar+ >5-25% CO₂
C1 Active gas 100% CO₂

Approvals

TÜV
GMAW +

Chemical composition (w%), typical, all weld metal

C	Mn	Si
0.08	1.70	0.85

Mechanical properties, all weld metal

	Process	Shielding gas	Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact (ISO), J		
							+20°C	-20°C	-50°C
Typical values after welding	GMAW	M21	AW	500	650	26	150	80	

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S185, S235, S27, 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
Boiler & pressure vessel steel	API 5LX	X42, X46, X52, X60
	EN 10216-1/	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
	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

Packaging, available sizes and identification

Process	Unit:	Sizes, mm						
		0.8	1.0	1.2	1.6	2.0	2.4	3.0
GMAW	15 kg spool B300	X	X	X	X			

Other sizes and packaging on request

Identification

Imprint: Revix®70S-6 Extra

Tip colour:

Revix®70S-6 Extra: rev.EN 20