

Mild steel solid wire

Classification

AWS A5.18/A5.18M	:ER70S-6
EN 1668	:W 42 5 W3Si1
EN 440	:G 46 4 M G3Si1

Solid wire/rod for welding of general constructions in mild steel

Smooth bead appearance

Stable arc and excellent feedability (Revix®70S-6)

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar 100%
GMAW	M21	Mixed gas Ar+ >5-25% CO ₂
	C1	Active gas 100% CO ₂

Approvals

	ABS	BV	DNV	GL	LR	RINA	TÜV	RMRS
GTAW							+	
GMAW	3SA, 3YSA	SA3YM	IIYMS	3YS	3S, 3YS	3YS	+	3S, 3YS

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

C	Mn	Si
0.08	0.9	0.6

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	-30°C	-40°C	-50°C
Typical values after welding	GTAW	I1	AW	460	580	26	170	170		120
	GMAW	M21	AW	520	600	25	110		70	

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
Fine grained steel	EN 10028-2	P235GH, P265GH, P295GH, P355GH
	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	3.2
GTAW	2 and 5 kg tube				x		x	x
GMAW	5 kg spool S200							
GMAW	15 kg spool B300							
GMAW	15 kg spool S300							
GMAW	250 kg WUTPACK®Profi							
GMAW	300 kg metal coil							
Other sizes and packaging on request								

Identification

Imprint: Revix®70S-6

Tip colour:

Revix®70S-6 : rev.EN 20

