

Mild steel solid wire

Classification

AWS A5.18/A5.18M :ER70S-6
 EN 440 :G 42 4 M G3Si1/G 42 2 C G3Si1

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% CO₂
 C1 Active gas 100% CO₂

Approvals

	ABS	BV	DB	DNV	GL	LR	RINA	TÜV	UDT	RS
GMAW	+	+	+	+	+	+	+	+	+	+

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

C	Mn	Si
0.07	1.45	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	-30 °C	-40 °C	
Typical values	GMAW	M21	AW	471	580	25		102	73
after welding		C1 required		439 min 375	547 490-660	28 min 22	102		min 47

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, S460

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 K300	X	X	X				
GMAW	15 kg spool B300-D300	X	X	X				
GMAW	250 kg WUTPACK®Eco	X	X	X				
GMAW	380 kg WUTPACK®Eco	X	X	X				
GMAW	500 kg WUTPACK®Eco	X	X	X				
Other sizes and packaging on request								

Identification

Imprint: Revix®SG 2

Tip colour:

Revix® SG 2: rev.EN 20