

Mild steel solid wire

Classification

AWS A5.18/A5.18M :ER70S-6
 EN 440 :G 42 4 M G3Si1 / G 38 3 C G3Si1

General Description

Solid wire for welding of structural steels
Excellent feedability and very consistent welding performance
No adjustments of welding parameters
Tight and stable arc with extremely low spatter
Better bead profile and appearance
Ultimate GMAW wire for robotics and hard automation
Also available in WUTPACK® Profi

Shielding gases (acc. EN 439)

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

Approvals

	BV	DNV	GL	LR	TÜV
GMAW	S3YM	IVY40	4Y40S	3S, 3Y40S	+

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

C	Mn	Si
0.08	1.55	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		
							-30	-40°C	-50°C
Typical values after welding	GMAW	M21	AW	490	590	27	100	60	40

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				
GMAW	15 kg spool S300	X	X	X	X			
	200 кг WUTPACK®Profi	X	X	X				

Other sizes and packaging on request

Identification

Imprint: Revix®SG 2 Ultra

Tip colour:

Revix® SG 2 Ultra: rev.EN 20