

Mild steel solid wire

Classification

AWS A5.18/A5.18M	:ER70S-3
EN 1668	:W 42 5 W2Si
EN 440	:G 42 2 M G2Si

General Description

Solid wire/rod for welding general construction in mild steel

High impact toughness

Stable arc and excellent feedability (Revix®70S-3)

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	TÜV
GTAW						+
GMAW	3YSA	SA3, 3YM	IIIYMS	3YS	3S, 3YS	

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

C	Mn	Si
0.08	1.1	0.6

Mechanical properties, all weld metal

	Process	Shielding gas	Condition	Yield	Tensile Strength	Elongation (%)	Impact (ISO), J	
				Strength (N/mm ²)	(N/mm ²)		-20°C	-50°C
Typical values	GTAW	I1	AW	450	560	26	170	100
after welding	GTAW	I1	SR 15h/620°C	410	525	26		80
	GMAW	M21	AW	500	575	25	95	

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
GTAW	2 and 5 kg tube				X	X	X	X
GMAW	15 kg spool B300	X	X	X				
	300 kg spool		X					
Other sizes and packaging on request								

Identification

Imprint: Revix®70S-3

Tip colour:

Revix®70S-3 : rev.EN 20