

CLASSIFICATIONS

EN ISO 14341-A

G 42 4 C1 / M21 3Si1

AWS A5.18

ER70S-6

KEY FEATURES AND APPLICATIONS

- Solid copper-coated wire for welding unalloyed and low-alloyed carbon-manganese steels.
- Provides a minimum yield strength of 420 MPa.
- Offers minimal spatter and can be used with both C1 and M21 shielding gases.
- Excellent mechanical properties at subfreezing temperatures down to -40°C.
- Ideal for a variety of applications, including structural steel, piping, automotive components and general metalworking.

BASE MATERIALS

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML

CHEMICAL COMPOSITION OF WIRE %

	C	Si	Mn	P	S	Ni	Cr	Mo	V	Cu	Al	Ti + Zr
MIN	0.06	0.70	1.30	-	-	-	-	-	-	-	-	-
MAX	0.14	1.00	1.60	0.025	0.025	0.15	0.15	0.15	0.03	0.35	0.02	0.15

Single values are maximum values according to EN ISO 14341

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
430 (≥420)	530 (500 - 640)	30 (≥20)	120 (≥47)	-40°C

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases

EN ISO 14175 - C1, M21

Polarity

DC+

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP10221	0.6	S300	15	72
XP10224	0.8	S300	15	72
XP10227	1.0	S300	15	72
XP10230	1.2	S300	15	72
XP10233	1.6	S300	15	72

0.7kg, 5kg and 250kg drums also available from stock