



### CLASSIFICATIONS

<b>EN ISO 14341-A</b>	<b>AWS A5.18</b>
G 42 3 C1 3Si1 / G 42 4 M21 3Si1	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 using M21 gas.
- 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 - M21

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
480 (≥420)	570 (500 - 640)	28 (≥20)	100 (≥47)	-40°C

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

### OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - C1, M21	DC+

### PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
WBR-1508	0.8	S300	15	72
WBR-1510	1.0	S300	15	72
WBR-1512	1.2	S300	15	72