TECHNICAL DATA SHEET

parweld
WELDING THE FUTURE

XP ER 70S-6 (SG3)

MILD STEEL

CLASSIFICATIONS

EN ISO 636-A	AWS A5.18
W 4Si1	ER70S-6

KEY FEATURES AND APPLICATIONS

- Solid copper-coated wire for welding unalloyed and low-alloyed carbon-manganese steels.
- Higher Si and Mn content which increases the weld metal strength.
- Offers minimal spatter and can be used with pure argon shielding gas.
- 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	Al	Ti + Zr	Cu
MIN	0.06	0.80	1.60	-	-	-	-	-	-	-	-	-
MAX	0.14	1.20	1.90	0.025	0.025	0.15	0.15	0.15	0.03	0.02	0.15	0.35

Single values are maximum values according to EN ISO 636

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)	Test Temperature
500	590	26	80	-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 - I1	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP10358	1.6	1000	5	PAP 20 Tube
XP10361	2.4	1000	5	PAP 20 Tube
XP10364	3.2	1000	5	PAP 20 Tube

MADE IN EU

This information is subject to change and was accurate to the best of our knowledge at the time of printing. Please refer to www.parweld.com for the latest revision.