

XP SG3 (G4Si1)

MILD STEEL



CLASSIFICATIONS

EN ISO 14341-A	AWS A5.18
G 42 3 C1 4Si1 / G 46 4 M21 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 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	0.80	1.60	-	-	-	-	-	-	-	-	-
MAX	0.14	1.20	1.90	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
470 (≥460)	550 (530 - 680)	28 (≥20)	91 (≥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
XP10254	0.8	S300	15	72
XP10257	1.0	S300	15	72
XP10260	1.2	S300	15	72
XP10266	0.8	Drum	250	4
XP10269	1.0	Drum	250	4
XP10272	1.2	Drum	250	4