

Copper coated solid wire, used for MIG welding on low alloy steels, which are meant to be carbonated or zinged. It is recommended in construction, for manufacturing parts in the automotive industry, manufacturing of pressurised devices and for shipbuilding. This wire offers high quality welding with steel of varying carbon concentrations.

■ Classification

AWS 5.18 : ER 70S-2

EN ISO 14341-A : G42 2 M G2Ti
G 38 2 C C2Ti

■ Applications

- Construction
- Automotive industry,
- Pressurised devices manufacturing,
- Shipbuilding.

■ Benefits

- High quality weld.
- Excellent ignition properties.
- Very low amount of welding projections.
- Welding in all positions.

■ Chemical properties

C %	Si %	Mn %	Ni %	Mo %	Cr %	V %	Zr %	Al %
0.06	1.10	0.50	0.012	0.012	0.15	0.10	0.09	0.10

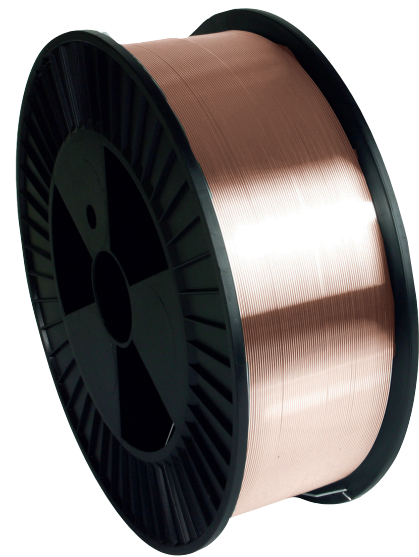
■ Mechanical properties

Re	Rm	A 5 d	KV 20°C	KV - 20°C
440 Mpa	520 Mpa	28 %	130 J	70 j

■ Recommendations

Ø wire (mm)	0.6	0.8
voltage (V)	15 ▶ 26	16 ▶ 28
current (A)	50 ▶ 180	60 ▶ 200

Gas protection complies with EN ISO 14175
100% CO₂ (C1) or Argon / CO₂ (M21, 8 < 20% CO₂)



Packaging

weight (kg)	Wire reel type		Wire diameter (mm)			
			Ø 0.6	Ø 0.8	Ø 1.0	Ø 1.2
5	S200	—	086760	086777	—	—