

## Mild steel solid wire

### Classification

AWS A5.18/A5.18M : ER70S-6  
ISO 14341-A : G 42 4 M G3Si1 / G 38 3 C G3Si1

### General description

**Solid wire for welding of structural steels**  
**Excellent feedability and very consistent welding performance**  
**No adjustments of welding parameters**  
**Tight and stable arc with extremely low spatter**  
**Better bead profile and appearance**  
**Ultimate GMAW wire for robotics and hard automation**  
**Also available in AccuTrak®**

### Shielding gases (acc. ISO 14175)

M21 Mixed gas Ar+ >15-25% CO<sub>2</sub>  
C1 Active gas 100% CO<sub>2</sub>

### Approvals

BV	DNV	GL	LR	TÜV
S3YM	IVY40	4Y40S	3S,3Y40S	+

### Chemical composition (w%) typical wire

C	Mn	Si
0.08	1.55	0.85

### Mechanical properties, typical, all weld metal

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)		
						-30°C	-40°C	-50°C
Typical values	M21	AW	490	590	27	100	60	40
	C1	AW	460	550	29	80	40	

### Materials to be welded

Steel grades	Standard	Type
<b>General structural steel</b>	EN 10025	S185, S235, S275, S355
<b>Ship plates</b>	ASTM A131	Grade A, B, D, AH32 t/m DH36
<b>Cast steel</b>	EN 10213-2	GP240R
<b>Pipe material</b>	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1/ EN 10217-1	P235T1, P235T2, P275T1 P275T2, P355N
	EN 10028-2	P235GH, P265GH, P295GH, P355GH
<b>Boiler &amp; pressure vessel steel</b>	EN 10025 part 3	S275, S355, S420
<b>Fine grained steel</b>	EN 10025 part 4	S275M, S275ML, S355M, S355ML, S420M, S420ML

### Packaging and available sizes

Unit type	Diameter (mm)			
	0.8	1.0	1.2	1.6
15 kg spool B300	X	X	X	
15 kg spool S300	X	X	X	X
250 kg Accutrak® Drum	X	X	X	
Other sizes and packaging on request				

SupraMIG® rev. EN 23

**Liability:** All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request