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REASON FOR ISSUE

Approvals updated.

GENERAL

A copper coated, manganese-silicon alloyed rod for GTAW of all general engineering and structural steels with a minimum yield strength of 380 MPa. The rod is usually welded with pure argon (I1) as the shielding gas.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Carbon-manganese steel

CLASSIFICATIONS Weld Metal

EN ISO 636-A W 38 3 W2Si

CLASSIFICATIONS Wire Electrode

EN ISO 636-A W2Si
SFA/AWS A5.18 ER70S-3

APPROVALS

ABS	3YSA
ABS	ER70S-s
BV	3YM
CE	EN 13479
DNV-GL	III YM (I1)
NAKS/HAKC	2.0-2.4 mm
VdTÜV	11141

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.10	0.06	0.14
Si	0.72	0.50	0.75
Mn	1.11	0.90	1.30
P	0.013		0.025
S	0.012		0.025

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			
	Ar (I1) EN			Ar (I1) AWS
	As welded			As welded
	Min	Max	Typ	Min
ReL (MPa)	380		420	400
Rm (MPa)	470	600	515	480
A4-A5 (%)	22		26	22
Charpy V at -18°C (J)				27
Charpy V at -30°C (J)	47		90	