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REASON FOR ISSUE

Revised chemical composition values

GENERAL

A copper coated, manganese-silicon alloyed rod for GTAW of all general engineering and structural steels with a minimum yield strength of max 420 MPa. The rod is usually welded with pure argon (I1) as the shielding gas.

Shielding Gas: Argon

Alloy Type: Carbon-manganese steel

CLASSIFICATIONS Weld Metal

EN ISO 636-A W 42 3 W3Si1

CLASSIFICATIONS Wire Electrode

EN ISO 636-A W3Si1
SFA/AWS A5.18 ER70S-6

APPROVALS

CE EN 13479

DB 42.039.07

VdTÜV 09124

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
Ar			
C	0.05	0.06	0.14
Si	0.8	0.80	1.00
Mn	1.4	1.40	1.60
P	0.015		0.025
S	0.015		0.025

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			
	Ar (I1) AWS	Ar (I1) EN		
	As welded Min	As welded Min	Max	Typ
ReL (MPa)	400	420		470
Rm (MPa)	480	500	660	560
A4-A5 (%)	22	22		26
Charpy V at -29°C (J)	27			
Charpy V at -30°C (J)		47		70

OTHER DATA

Lengths of rods: 1000 mm.

The wire rods are delivered in boxes of 5.0 kg net weight.