

Welding consumables GMAW solid wire electrode for:

unalloyed steels

WDI 15 SG • VDG 15/60 • WEKO 2 • HO 2 • <i>Arctron 2</i>						
Standard designation	DIN EN ISO 14341-A		AWS A 5.18			
	G3Si1		ER70 S-6			
Properties and application range	Welding wire for MAG-welding of unalloyed and low-alloyed steels.					
Materials being suitable for welding	DIN 1629 St 37.0, St 44.0, St 52.0 DIN 1630 St 37.4, St 44.4, St 52.4 DIN 1681 GS 38, GS 45, GS 52 DIN 17102 StE 255, StE 315, StE 380 DIN 17175 St 35.8, St 45.8, 19 Mn 5 EN 10025 S185, S355J2G3 EN 10028-2 P235GH, P265GH, P295GH, P355GH EN 10028-3 P275N, P355N EN 10113-2 S355N construction steels A-E, A 32 - E 32, A 36 - E 36					
Reference analysis (%)	C	Si	Mn			
	0,07	0,85	1,45			
Mechanical performance according to EN 1597-1	post-weld heat treatment	inert gas	yield strength N/mm ²	all-weld metal tensile strength N/mm ²	elongation (L ₀ =5d ₀) %	energy absorbed ISO-V(Joule)
	U	C	420	520	25	85
	U	M2	420	520	27	100
Welding position						kind of current= + inert gas (EN 439) Argon mixed gas CO ²
Qualification tests and approvals	① ② WDI 15 SG: TÜV, DB ① ② VDG 15/60: TÜV, DB, ABS, DNV, GL, LR ① ② WEKO 2: TÜV, DB, ABS, DNV, GL, LR ① ② HO 2: TÜV, DB ① ② <i>Arctron 2</i> : TÜV, DB, ABS, DNV, GL, LR					
	① = Site Hamm ② = Site Rothenburg					
Wire packaging	Spooling types see from page 78 wire diameter 0,8 - 1,6 mm other dimensions on demand					

GMAW solid wire electrode

submerged welding

gas welding staves