

<b>CATEGORY</b>	GTAW Solid wires	
<b>TYPE</b>	Copper coated welding wire for GTAW welding of un and -low alloyed steels	
<b>APPLICATIONS</b>	Shipbuilding, piping, root welding, bridges, repair, construction, offshore, car-plate welding etc...	
<b>PROPERTIES</b>	Extreme easy to weld with excellent welding properties and increased yield strenght.	
<b>CLASSIFICATION</b>	AWS EN ISO F-nr FM	A 5.18: ER 70S-6 636-A: W 50 5 4 Si1 6 1

SUITABLE FOR	Materials	DIN	EN	ASTM
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
	Fine grain steels	StE 255 to StE 460	S235 - S460QL1	-
	API-standard	X 42, X65, X 70	X 42, X65, X 70	-
	Domex 460 MC			

<b>APPROVALS</b>	TÜV (12399.00) CE
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**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu	Al	Ti+Zr
0.08	0.95	1.75	0.012	0.015	0.01	0.01	0.01	0.001	0.009	0.002	0.013

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V
As Welded /	520	600	24	-20°C: 170, -40°C: 110

**WELDING PARAMETERS / PACKING**

D (MM)	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING
		CURRENT (A) DC-	SINGLE (KG)	MASTER (KG)
1,6 X 1000		50-90	5	25
2.0 X 1000		70-110	5	25
2.4 X 1000		110-180	5	25
3.2 X 1000		150-250	5	25

<b>REDRYING TEMPERATURE</b>	Not required
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<b>GAS ACCORDING EN 14175</b>	I1
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