

Copper Coated Solid Wire

Standards

AWS A5.18-93: ER 70 S-6 EN 440-94: G 4 Si 1 DIN 8559: SG3

Approvals

TÜV • DB

Welding Positions



Main Features

Copper coated solid wire for GMAW welding in all position. To be used with Ar/CO₂, Ar/CO₂/O₂ or CO₂ shielding gas.

Suitable for single pass or multipass welding of non-alloy steels, for C-Mn steels and for fine grain steels, with tensile strength up to 590 N/mm² (type S355J2G3 EN 10025 FE 510/St 52 and similar). The higher Si-Mn content guarantees elevated mechanical properties and a moderate deoxidizer deposit thus less susceptible to defectives deriving from presence of mill scale or other impurities in the parent metal.

Wire Chemical Analysis %

C	0.06 - 0.10	P	≤ 0.020
Mn	1.60 - 1.80	Cu	≤ 0.25
Si	0.80 - 1.10		
S	≤ 0.020		

Current

DC +

Gas

Ar / CO₂ - Ar / CO₂ / O₂ - CO₂ (EN 439: M2, M3, C1)

All-weld Metal Mechanical Properties

GAS	Heat treatment	Rm N/mm ²	Re N/mm ²	A5 (%)	Kv J - 20°C	Kv J - 40°C
Ar / CO ₂ (M21)	As welded	530 - 600	≥ 460	≥ 24	≥ 80	≥ 47

Packing	Weight		Diameter											
	Kg	lb	0.6mm .023"	0.8mm .030"	0.9mm .035"	1.0mm .040"	1.2mm .045"	1.6mm 1/16"	.062					
D 100 R	0,9	2
D 200 R	5	11
D 300 R	15	33
D 300 L	15	33
K 300 R	15	33
K 300 L	15	33
S 300 R	15	33
S 300 L	15	33
D 405 R	27	60
D 450 R	100	220
D 760 R	300	660
FC	250	550
FE	250	550
FG	400	880
SpeedPack 250	250	550
SpeedPack 450	990	
SpeedPack 500	1100	
SpeedPack 550	1210	

SPEED PACK

[Technical data](#)

Main Applications

Boiler manufacturing or the chemical-petrochemical industry, Industrial machinery construction, Metal working industry, Pipes manufacturing, Car production and electro-domestic appliances.