

## CLASSIFICATION

<b>AWS A5.18</b>	ER70S-6	<b>A-Nr</b>	1	<b>Mat-Nr</b>	1.5125
<b>EN ISO 636-A</b>	W 42.5 W35i1	<b>F-Nr</b>	6		
		<b>9606 FM</b>	1		

## GENERAL DESCRIPTION

Solid rod for welding general construction in mild steel  
 Smooth bead appearance

## SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

## APPROVALS

<b>TÜV</b>	<b>CE</b>
+	+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

<b>C</b>	<b>Mn</b>	<b>Si</b>
0.1	1.5	0.9

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)		
						-20°C	-30°C	-50°C
Typical values	I1	AW	460	580	26	170	170	120

## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
General structural steels	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 to DH 36.
Cast steels	EN 10213-2	GP240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
Boiler & pressure vessel steels	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	EN 10025 part 3	S275, S355, S420
	EN 10025 part 4	S275M, S275ML, S355M, S355ML, S420M, S420ML

## PACKAGING AND AVAILABLE SIZES

Diameter [mm]	1.6	2.0	2.4	3.2
5 kg PE-Tube	X	X	X	X

Note : Cut length = 1000 mm

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