

MIGWELD 3

MIG/MAG Wires [GMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14341-A : G 46 4M M21 4Si1 / G 42 3 C1 4Si1 DIN 8559 : SG 3 AWS A-5.18 : ER 70 S-6 W.Nr. : 1.5130	UDT, TUV	Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Shipbuilding&Offshore Agriculture Light construction and hobby

- Solid copper coated welding wire for welding mild steels, unalloyed and low alloyed steels.
- Very little spatter.
- During root pass, the melting of the wire is continuous without any interruptions.
- The material is characterized by high wettability of the walls.

Application

Steel constructions, machines, pipelines, boiler installations, ship steels, etc.

Base material

	EN	DIN
Construction steels	S275-S355, P235TR2-P355T2, E295, E335, E360, C10-C35	St44, St44-2, St44-3, St52, St52-3, St 37-4, St44-4, St52-4, St 50-2, St60-2, St70-2, C10-C35, Ck10-Ck35
Fine-grained steels	S255N-S420N, P255NH-P355NH	StE255-StE420, WStE 255-WStE 355
Steel for work at elevated temperatures	P235G1TH-P255G1TH	St35-8, St45-8
Steels for pressure vessels	P235GH,P265GH, P295GH, P355GH	HI, HII, 17Mn4, 19Mn6
Shipbuilding steels		A, B, C, D, E, AH32-EH36
Castings	GE200, GE240, GE260	GS-38, GS-45,GS-52
Pipelines	L210-L415NB	StE 210-7 - StE 415-7, X42, X46, X52, X60

Typical chemical composition %

C	Si	Mn	P	S
0,08	1,0	1,7	<0,025	<0,025

Typical mechanical properties

Yield strength Re [N/mm2]	>460
Tensile strength Rm [N/mm2]	530-680
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (-40°C) /
Shielding gases acc. to EN ISO 14175	C1 - 100% CO2 / M21 - Ar + 15 - 25% CO2 / M23 - Ar + 5%CO2 + 4%O2 /

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	60-180	18-24	15,0
1,0	90-300	19-32	15,0
1,2	130-360	19-35	15,0
1,6	200-400	22-36	15,0

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