

V2L5/ HP Special

CLASSIFICATION

AWS A5.18/A5.18M – ER70S-6
EN ISO 14341-A – G 46 4 M 3Si1 / G 42 3 C 3Si1

GENERAL DESCRIPTION

Solid wire for semi-automatic and automatic welding applications
Good feedability, consistent welding performance
Very good weldability, stable arc, and low spatter
High productivity

WELDING POSITIONS [ISO/ASME]



SHIELDING GASES [ACC. ISO 14175]

M21 Mixed gas Ar+> 15-25% CO₂
C1 Active gas 100% CO₂

APPROVALS

TÜV CE
+ +

CHEMICAL COMPOSITION [W%] TYPICAL WIRE

| C | Mn | Si |
|-------|-----|------|
| 0.078 | 1.4 | 0.85 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| Typical Values | Shielding gas | Condition | Yield Strength | Tensile Strength | Elongation | Impact ISO-V[J] | |
|----------------|---------------|-----------|----------------------|----------------------|------------|-----------------|-------|
| | | | [N/mm ²] | [N/mm ²] | [%] | -30°C | -40°C |
| | M21 | AW | 502 | 574 | 28 | | 102 |
| | C1 | AW | 486 | 570 | 29 | 71 | |

EXAMPLES OF MATERIALS TO BE WELDED

| Steel grades | Standard | Type |
|--------------------------------|-----------------|--|
| General structural steel | EN 10025 | S185, S235, S275, S355 |
| Ship plates | ASTM A131 | Grade A,B,D, AH32 to DH36 |
| Cast steel | 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 |
| Boiler & pressure vessel steel | API 5LX | X42, X46, X52, X60 |
| | EN 10216-1 | P235T1, P235T2, P275T1 |
| | EN 10217-1 | P275T2, P355N |
| Fine grained steel | EN 10028-2 | P235GH, P265GH, P295GH, P355GH |
| Fine grained steel | EN 10025 part 3 | S275, S355, S420 |
| | EN 10025 part 4 | S275M, S275ML, S355M, S355ML, S420M, S420ML, S460 |

PACKING AND AVAILABLE SIZES

| | Diameter [mm] | 0.8 | 1.0 | 1.2 | 1.6 |
|-------|-------------------|-----|-----|-----|-----|
| Unit: | 5 kg spool S200 | X | | X | |
| | 15 kg spool B300 | | | X | X |
| | 15 kg spool BS300 | | X | X | X |
| | 15 kg spool S300 | | | X | X |
| | 250 kg Eco Drum | | X | X | |
| | 500 kg Eco Drum | | X | X | X |

Other sizes and packaging on request

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance