

# V3L5/ HP Special

## CLASSIFICATION

AWS A5.18/A5.18M – ER70S-6  
EN ISO 14341-A – G 46 5 M 4Si1 / G 46 3 C 4Si1

## GENERAL DESCRIPTION

Coppered 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]



PA/TG



PB/2F



PC/2G



PD/4F



PE/4G



PF/3G up

## SHIELDING GASES [ACC. ISO 14175]

M21 Mixed gas Ar+> 15-25% CO<sub>2</sub>  
C1 Active gas 100% CO<sub>2</sub>

## APPROVALS

TÜV	CE
+	+

## CHEMICAL COMPOSITION [W%] TYPICAL WIRE

C	Mn	Si
0.08	1.70	0.85

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical Values	Shielding gas	Yield Strength Condition	Yield Strength [N/mm <sup>2</sup> ]	Tensile Strength [N/mm <sup>2</sup> ]	Elongation [%]	Impact ISO-V[J]	
						-40°C	-50°C
	M21	AW	490	590	27		90
	C1		460	560	25	70	

## 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
	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steel	EN 10025 part 3	S275, S355, S420, S460
	EN 10025 part 4	S275M, S275ML, S355M, S355ML, S420M, S420ML, S460, P460, S460ML

## PACKING AND AVAILABLE SIZES

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



The strong connection