

FORPEX 3



CLASSIFICATION

AWS A5.18/A5.18M: ER70S-6
EN-ISO 14341-A : G 46 4 M21 4Si1

GENERAL DESCRIPTION

- Solid wire type SG3 for semi-automatic welding applications
- Standard feedability and welding performance
- Increased levels of Mn & Si

WELDING POSTIONS



SHIELDING GASES

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

APPROVALS

CE

CHEMICAL COMPOSITION [W%] TYPICAL WIRE

C	Mn	Si
0,08	1,7	0,9

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical Values	Shielding gas	Condition	Yield Strength [MPa]	Tensile Strength [MPa]	Elongation [%]	Impact ISO-V [J] -40°C
	M21	AW	470	540	28	100

EXAMPLES OF MATERIALS TO BE WELDED

Steel grade	Standard	Type
General structural steel	EN 10025	S185 - S235 - S275 - S355
Ship plate	ASTM A131	Grade A,B,D AH32 to DH36
Pipe steel	API	X52 - X60
	EN 10208-1	L210 - L240 - L290 - L360
	EN 10208-2	
Fine grained steel	EN 10028-2	P235GH - P265GH - P295GH - P355GH
	EN 10025 part 3	S275 - S355 - S420
	EN 10025 part 4	S275M/ML - S355M/ML - S420M/ML

This material overview cannot be all-encompassing. Contact Valk Welding for questions on material not mentioned on this datasheet

PACKING AND AVAILABLE SIZES

Unit	Diameter [mm]	0.8	1.0	1.2	1.6
	BS300-15kg	+	+	+	
	Drum 250kg		+	+	

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

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