

ENERGOMAG 3-S



Solid wire GMAW

Classifications	<u>DIN 8559</u>	<u>EN ISO 14341-A</u>	<u>AWS A 5.18</u>
	SG3	G 46 4 M21 4Si1/ G 42 4 C1 4Si1	ER 70S-6

Description Copper-coated solid wire used for MIG/MAG welding with mixed-gases (Ar/ CO₂, Ar/ CO₂/O₂) as well as with CO₂. Prepared from selected wire rod is provided on BS300 spool to ensure excellent feeding characteristics, contribute to smooth, sound weld and save time during spool changing. Suitable for welding low-carbon structural steels, boiler steels as well as carbon-manganese steels (type S355J2G3 EN 10025). Higher content of silicon and manganese allows to increase the weld metal strength and sensitivity to surface impurities. Provides stable arc and low spatter.

Base materials Steels up to a yield strength 460 MPa for M21/ 420MPa for C1
S235JR-S355JR, S235J0-S355J0, S450J0, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240,

Typical composition of solid wire (%)	C	Si	Mn	S	P	Cu
	0,06-0,14	0,80-1,2	1,6-1,9	≤0,025	≤0,025	≤0,35

Mechanical properties of all-weld metal (acc to EN 15792-1, min. values, shielding gas M21)	Yield strength 0,2% N/mm ²	Tensile strength N/mm ²	Elongation (L ₀ = 5d ₀) %	Impact values in J CVN -40 °C
	≥ 460	530-680	≥ 20	≥ 47

Welding positions



Polarity =+

Shielding gases: (EN ISO 14175: M2, M3, C1)

Dimensions (mm) 0,8-1,6

Certificates CE, TÜV, DB

