

UltraMag®

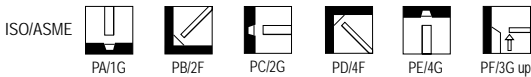
CLASSIFICATION

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



SHIELDING GASES (ACC. ISO 14175)

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

APPROVALS

| ABS | BV | DNV | GL | LR | TÜV | CE |
|-----|----|-----|----|----|-----|----|
| + | + | + | + | + | + | + |

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

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

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

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

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 |
| | API 5LX | X42, X46, X52, X60 |
| | EN 10216-1 | P235T1, P235T2, P275T1 |
| | EN 10217-1 | P275T2, P355N |
| Boiler & pressure vessel 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 |

PACKAGING 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 Accutrak® Drum | | X | X | |
| 500 kg Accutrak® Drum | | X | X | X |

Other sizes and packaging on request

Ultramag® : rev. EN26

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.
Fumes: Material Safety Data Sheets (MSDS) are available on our website.

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THE WELDING EXPERTS®