

IABCO ER70S-6 MIG

MIG/GMAW wire for mild steel

Product name	IABCO ER70S-6 MIG
Classification EN ISO	14341-A: G 3Si1 / G 42 5 M21 3Si1
Material No.	1.5125
Classification AWS	A5.18: ER70S-6
Approvals	TÜV 12682.00, CE.
Applications	MIG/GMAW wire for welding standard CMn structural steels. Typical applications would include shipbuilding, pressure vessels and construction.
Base materials	For steels up to a yield strength of 420MPa (60ksi). ASTM: A36, A106 grades A/B/C, A139, A210 grades A1/C, A216 grades WCA/WCB/WCC, A234 grade WPB, A334 grade 1, API 5L grades X42-X60. S185-E360, S235JR-S355JR, S235J0-S355J0, S235J2-S355J2, S275N-S420N, S275NL-S420NL, S275M-S420M, S275ML-S420ML, P235GH-P355GH, P275N-P355N, P275NL1-P355NL1, P275NL2-P355NL2, P355M-P420M, P355ML1-P420ML1, P355ML2-P420ML2, P355Q, P355QL1, P355QL2.
Typical analysis of wire, weight %	C: 0.09 Si: 0.87 Mn: 1.47
Typical heat treatment ⁽¹⁾	Preheat and PWHT are generally not necessary but actual requirements will depend on the grade and thickness of material being welded and any design codes that apply.
Mechanical properties of weld deposit ⁽²⁾	M21 shielding gas: 0.2% proof stress, Rp0.2%: ≥420MPa. Tensile strength, Rm: ≥500MPa. Elongation, 4d/5d: ≥22/20%. Impact ISO-V, -50°C: ≥47J. C1 shielding gas: 0.2% proof stress, Rp0.2%: ≥420MPa. Tensile strength, Rm: ≥500MPa. Elongation, 4d/5d: ≥22/20%. Impact ISO-V, -30°C: ≥47J.
Other products	SAW: S1, S2, S3, S2Si, S3Si. MIG/GMAW: ER70S-2, ER70S-3, SG3. TIG/GTAW: ER70S-2, ER70S-3, ER70S-6, SG3. Gas welding: A1, A2.

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.