



MIG F56

Classification

AWS A5.18 : ER70S-3
ISO 14341-A : G 38 3 M21 2Si

ISO 14341-A : G 38 3 C1 2Si

Description & Applications

Copper coated solid wire for gas (Ar + CO₂ or 100% CO₂) metal arc welding of low alloyed standard construction / boiler steels like E36 (S235-S355; P235-P310).

Main applications: For general metal constructions, ship building etc. Advise in piping systems, for root passes and high quality assemblies...

Base material:

Construction steels for general use:

EN	ASTM
S275 – S355	A106 grade A, B, C
P275 – P355	A131 grade A, B, D
L210 – L360	A139
	A210 grade A1, C

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti+Zr	V	P	S
Min	0.06	0.50	0.90									
Max	0.14	0.75	1.30	0.15	0.15	0.15	0.35	0.02	0.15	0.03	0.025	0.025
Type	0.07	0.55	1.2	0.03	0.02	0.01	0.10	0.005	0.01	0.005	0.015	0.010

All Weld Metal Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	400	490	22	-30°C >47
Max		600		
Type	430	530	28	-30°C 55

* Shielding gas: M21 (Ar + CO₂)

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	60 - 200	16 - 28	ISO 14175: M21 (Ar/CO ₂) C1 (100% CO ₂) 12-15 l/min
	1.0	80 - 260	17 - 32	
	1.2	100 - 360	18 - 34	

FT En-MA02-210427

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