MIG F57HP

Classification

AWS A5.18 : ER70S-6
ISO 14341-A : G 46 4 M21 3Si1
ISO 14341-A : G 46 3 M14 3Si1
ISO 14341-A : G 42 2 C1 3Si1

Description & Applications

High performance copper coated solid wire for gas (Ar + CO_2 or 100% CO_2) metal arc welding of low carbon and low alloyed steels (S235-S355). Excellent mechanical properties down to -40°C.

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

Base material:

Construction steels for general use, Tube steels, Ship steels:

EN	*Ship steels*	*ASTM*
S185 – S355	Quality A and B	A285 grade C
P235 – P355		A442 grade 55, 60
L210 – L360		A414 grade C, D, E, F
		A515 grade 55, 60, 65

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti+Zr	V	P	S
Min	0.06	0.80	1.40									
Max	0.14	1.00	1.60	0.15	0.15	0.15	0.35	0.02	0.15	0.03	0.025	0.025
Type	0.07	0.85	1.45	0.04	0.04	0.01	0.15	0.01	0.01	0.01	0.015	0.010

All Weld Metal Mechanical Properties*

	R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	460	530	22	-40°C	>47
Max		680			
Type	480	580	28	-40°C	80

* Shielding gas: M21 (Ar + CO_2)

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2	60 - 200 80 - 260 100 - 360	16 - 28 17 - 32 18 - 34	ISO 14175: M21 (Ar/CO_2) C1 (100% CO_2) 12-15 l/min

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