



# 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<sub>2</sub> or 100% CO<sub>2</sub>) 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 <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	460	530	22	-40°C
Max		680		>47
Type	480	580	28	-40°C
				80

\* Shielding gas: M21 (Ar + CO<sub>2</sub>)

## 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 <sub>2</sub> ) C1 (100% CO <sub>2</sub> ) 12-15 l/min
	1.0	80 - 260	17 - 32	
	1.2	100 - 360	18 - 34	

FT En-MA06-191113

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