

Classifications

EN ISO 14341-A:2008	: G 50 0 C G0	JIS Z 3312	: YGW18
EN ISO 14341-B:2008	: G 55A 0 U C G18		
AWS A5.18-05	: ER70S-G		

Description

- For butt and fillet welding of machineries, bridges, heavy equipment and pressure vessels
- Excellent mechanical properties on high heat input(40KJ/cm) or interpass temperature(350℃)
- High deposition rate per unit time
- Beautiful weld appearance due to excellent arc stability

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Ti
0.07	0.92	1.92	0.012	0.004	0.18

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) 0℃	Remarks
AWS A5.18	min. 400	min. 480	min. 22		
EN ISO 14341-B	min. 460	570~770	min. 17	≥ 47	CO ₂
Example	580	640	27	170	CO ₂

Operating data

	Dia.(mm)	1.2	1.4
Current (Amp.)	Flat (PA/1G)	100 ~ 350	140 ~ 400
	Vertical (PF/3G)	50 ~ 180	100 ~ 250
	Overhead (PE/4G)	50 ~ 180	100 ~ 250

Polarity and Shielding gas

- DCEP (DC+)
- CO₂ : 100% CO₂ (15~25ℓ /min.)