VENVU M 14

Solid wire

Classifications

EN ISO 14341-A	AWS A5.18
G42 4 M21 G3Si1	ER70S-6

Characteristics and typical fields of application

Solid wire for single or multipass welding of carbon, carbon-manganese and similar steels, including fine grain ones, with Ar-CO2 or pure CO2 shielding gas. Features include: high yield, good weldability also in upward vertical position, excellent bead appearance, less spatter for the whole range of welding parameters, less silicates. This wire can be used for automated and robotized applications.

Base materials

EN 10025: S185 - S235 - S275 - S355
EN 10028-2: P235GH - P265GH - P295GH - P355GH - P275N/NH - P355N/NH
EN 10113-2: S275N/M - S355N/M
EN 10207: P235S - P265S

Typical analysis of all-weld metal (wt.-%)

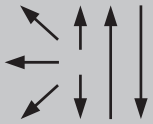
C	Mn	Si	P	S	GAS
0.08	**1.45**	**0.85**	**< 0.025**	**< 0.025**	**M21**
0.08	**1.45**	**0.85**	**< 0.025**	**< 0.025**	**C1**

Mechanical properties of all-weld metal – typical values (minimum values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	-20°C	-30°C
u	**440**	**540-570**	**24**	**60**	**47**

u: untreated, as welded – shielding gas Ar + 18% CO_2

Operating data



Ø (mm)	Current A	Voltage V
0.80	35 - 250	14 - 30
1.00	45 - 270	15 - 32
1.20	50 - 330	16 - 35
1.40	60 - 370	20 - 49
1.60	65 - 390	20 - 40

Approvals

ABS • DNV • GL • RINA • TÜV • DB-CE