



IRON AND STEEL
PRODUCTS

Solid Wire For GMAW

Copper Coated and Copper Free

- **Product description:**

Welding wires produced by Zanjan Wire Industry Is a copper free Mn-Si-alloyed ER70S-6, G3Si1 solid wire for the GMAW.

Characteristic features include excellent start properties; trouble-free feeding at high wire speeds and lengthy feed distances; a very stable arc at high welding currents; extremely low levels of spatter; low fume emission; reduced contact tip wear and improved protection against corrosion of the wire.

- **Product Standard:**

DIN EN ISO 14341	Product Code: G3Si 1
AWS A5.18	Product Code: ER70S-6
JIS Z 3312	Product Code : YGW12

- **Technical specifications:**

1. Chemical composition of welding wire

C	Si	Mn	P	S
0.06-0.15	0.80-1.15	1.40-1.85	Max 0.025	Max 0.035

2. Mechanical properties of all-weld

Yield stress (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact Test
Min 400	Min 480	Min 22	According to EN and AWS

Packaging

Wire diameter (mm)				weight	
0.80	1.00	1.20	1.60	Spool weight	Drum weight
✓	✓	✓	✓	15 kg	250 kg

Welding parameters

Arc type	Wire Diameter (mm)	Current (A)	Voltage (V)
Short Arc	0.80	25-85	11-19
Short Arc	1.00	110-150	20-24
Short Arc	1.20	230-285	17-28
Spray Arc	1.20	280-340	35-44
Spray Arc	1.60	280-480	35-44







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