

ER 70S-2 (A15)

Mild Steel WIRE/GMAW

Standards

EN/ISO-Standard - 14341-A
EN/ISO-Classification - G 42 3 M21 2Ti

AWS-Standard - A5.18
AWS-Classification - ER 70S-2

Features and Applications

- Micro-alloyed steel, triple de-oxidised (Ti, Al, Zr) suitable for the welding of C-Mn and low-alloy steels.
- Ideal for use on greasy and oxidised surfaces subsequent to any coating processes. (i.e. galvanised steel).
- Works well at low temperatures.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on tanks, containers, car industry, structural work, household appliances, pipelines, boilers, naval & petrochemical sectors etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

A106, A210, A234 S355J2, S380N, P235GH, GS 45, P295GH, P355GH, S355N*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Shielding Gases

EN ISO 14175 - C1, M20, M21, M33

Polarity

DC (+)

Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	60-190	80-290	120-370
Voltage (V)	18-24	18-32	18-35

Mechanical Properties (Typical)

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)	Test Temperature
560	480	24	>50	-30°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % ^a	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.06	0.60	1.20	<0.020	<0.020	<0.25	<0.10	<0.10	<0.050	0.100	<0.030	<0.15

^a (includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010202856	0.80	15	D300 PLW	72
3010202858	1.00	15	D300 PLW	72
3010202860	1.20	15	D300 PLW	72

Liability: Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

