

# CF2 - G3Si1 (Copper Free)

Mild Steel WIRE/GMAW

## Standards

EN/ISO-Standard - 14341-A

AWS-Standard - A5.18

EN/ISO-Classification - G 42 3 C1 / G 42 4 M21 3Si1

AWS-Classification - ER 70S-6

## Features and Applications

- A non-copper coated solid wire suitable for single pass or multipass welding of unalloyed and low-alloyed carbon-manganese steels.
- Environmentally friendly when compared against traditional copper wires offering less fume and smoke in the working environment.
- Advantages of a stable arc when working with increased welding speeds that achieves high quality welds with almost no spatter.
- Good mechanical properties at sub-zero temperatures down to -40°C.
- Vacuum-sealed plastic bag packaging to prevent moisture absorption.
- Fitted with alignment hole clip to ensure smooth feeding.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on boilers, industrial machinery, bridges, shipbuilding, automotive, rail, structural and engineering fabrications 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

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML\*

\* Illustrative, not exhaustive list

## Welding Positions

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

## Shielding Gases

EN ISO 14175 - C1, M21

## Polarity

DC (+)

## Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu %	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.07	0.85	1.45	<0.025	<0.025	0.010	<0.15	<0.15	<0.15	<0.020	<0.030	<0.15

## Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010200837	0.80	15	BS300 PLW	72
3010200839	1.00	18	BS300 PLW	56
3010200841	1.20	18	BS300 PLW	56

Drums also available.

## Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	60-200	80-300	120-380
Voltage (V)	18-24	18-32	18-34

## Mechanical Properties (Typical) - C1

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
540	440	30	70	-30°C

## Mechanical Properties (Typical) - M21

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
580	460	26	90	-40°C

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

**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.



Exclusive Partnership



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