CF3 - G4Si1 (ENDURANCE PAC) Mild Steel WIRE/GMAW

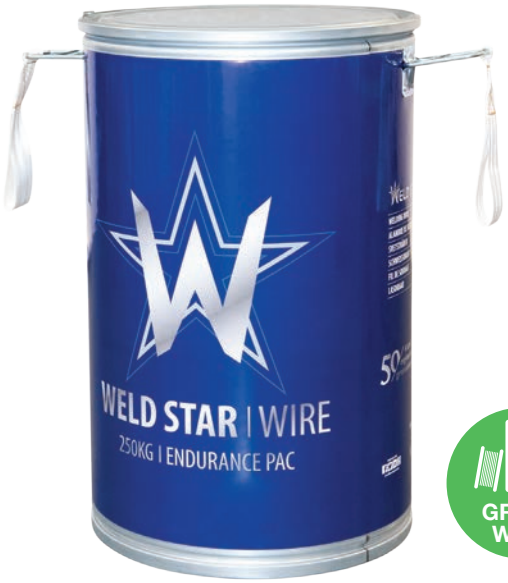
Standards

EN/ISO-Standard - 14341-A
EN/ISO-Classification - G 42 3 C1 / G 46 4 M21 4Si1

AWS-Standard - A5.18
AWS-Classification - ER 70S-6

Features and Applications

- Bulk wire drum system that offers a high productivity solution for continuous high volume welding applications.
- Environmentally friendly when compared against traditional copper wires offering less fume and smoke in the working environment.
- A non-copper coated solid wire suitable for single pass or multipass welding of unalloyed and low-alloyed carbon-manganese steels.
- The higher Si-Mn content increases the weld metal strength and leaves a good bead appearance.
- Designed for semi-automatic and full-automatic GMAW applications.
- Good mechanical properties at sub-zero temperatures down to -40ºC.
- Typically used on boilers, industrial machinery, bridges, shipbuilding, automotive, rail, structural and engineering fabrications.
- 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**



Wire Length	0.80	1.00	1.20
Meters	68,375	43,062	29,625
Miles	42.50	26.76	18.41

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 S460, P460, S460ML*

* 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 (+)

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^2)	Yield Strength (N/mm^2)	Elongation (%)	Impact Strength (J)	Test Temperature
570	460	36	58	-30ºC

Mechanical Properties (Typical) - M21

Tensile Strength (N/mm^2)	Yield Strength (N/mm^2)	Elongation (%)	Impact Strength (J)	Test Temperature
590	490	28	88	-40ºC

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 %	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.08	0.95	1.70	<0.020	<0.020	0.010	<0.15	<0.15	<0.050	<0.020	<0.030	<0.15

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010201380	0.80	250	Drum	4
3010201384	1.00	250	Drum	4
3010201388	1.20	250	Drum	4

BS300 spools also available.

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.