

Classifications

EN ISO 14341-A:2008	: G 42 2 C G2Si1	KS D 7025	: YGW14
EN ISO 14341-B:2008	: G 49A 2 C G3	JIS Z 3312	: G 43 A 0 U C 3
AWS A5.18-05	: ER70S-3		

Description

- For butt and fillet welding of ship-building, bridges, structural steel, steel buildings, machineries and vehicles
- Suited for welds that are subject to enamelling or galvanising due to low Si-content
- Excellent performance of root welding for multiple pass welds
- Suited for application of sheet metal with superior arc stability on low welding current

Typical chemical composition of wire (%)

C	Si	Mn	P	S
0.07	0.67	1.20	0.015	0.011

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -20°C	Remarks
AWS A5.18	min. 400	min. 480	min. 22	≥ 27	CO ₂
EN ISO 14341-A	min. 420	500~640	min. 20	≥ 47	CO ₂
Example	430	520	33	90	CO ₂

Operating data

Dia.(mm)	1.2	1.4
Current (Amp.)		
Flat (PA/1G)	100 ~ 350	140 ~ 400
Vertical (PF/3G)	70 ~ 200	100 ~ 250
Overhead (PE/4G)	70 ~ 200	100 ~ 250

Polarity and Shielding gas

- DCEP (DC+)
- CO₂ : 100% CO₂ (15~25ℓ /min.)

Approvals

Shielding gas	ABS	DNV	LR	KR	NK
CO ₂	3SA	III YMS	3YS H15	3YSG	KSW53G

* Others: CWB, KS, JIS