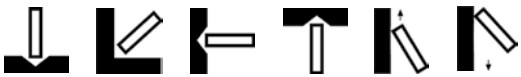
WDI 15 SG • VDG 15/60 • WEKO 2 • HO 2 • Arctron 2

Standard designation	**DIN EN ISO 14341-A** **G3Si1**			**AWS A 5.18** **ER70 S-6**		
Properties and application range	Welding wire for MAG-welding of unalloyed and low-alloyed steels.					
Materials being suitable for welding	DIN 1629 ..... St 37.0, St 44.0, St 52.0 DIN 1630 ..... St 37.4, St 44.4, St 52.4 DIN 1681 ..... GS 38, GS 45, GS 52 DIN 17102 ..... StE 255, StE 315, StE 380 DIN 17175 ..... St 35.8, St 45.8, 19 Mn 5 EN 10025..... S185, S355J2G3 EN 10028-2 ..... P235GH, P265GH, P295GH, P355GH EN 10028-3 ..... P275N, P355N EN 10113-2 ..... S355N construction steels ..... A-E, A 32 - E 32, A 36 - E 36					
Reference analysis (%)	**C** 0,07	**Si** 0,85	**Mn** 1,45			
Mechanical performance according to EN 1597-1	post-weld heat treatment **U** **U**	inert gas **C** **M2**	yield strength N/mm² **420** **420**	all-weld metal tensile strength N/mm² **520** **520**	elongation (L_0=5d_0) % **25** **27**	energy absorbed ISO-V(Joule) **85** **100**
Welding position						kind of current= **+** inert gas (EN 439) Argon mixed gas CO_2
Qualification tests and approvals **1** = Site Hamm **2** = Site Rothenburg	**1 2 WDI 15 SG:** TÜV, DB **1 2 VDG 15/60:** TÜV, DB, ABS, DNV, GL, LR **1 2 WEKO 2:** TÜV, DB, ABS, DNV, GL, LR **1 2 HO 2:** TÜV, DB **1 2 Arctron 2:** TÜV, DB, ABS, DNV, GL, LR					
Wire packaging	Spooling types see from page 78 **wire diameter 0,8 - 1,6 mm** other dimensions on demand					