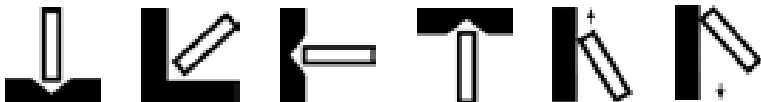


Welding consumables GMAW solid wire electrode for: unalloyed steels

WDI 16 SG • VDG 16/60 • WEKO 4 • HO 3 • *Arctron* 3

Standard designation	DIN EN ISO 14341-A G4Si1			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, StE 420 DIN 17175 St 35.8, St 45.8, 19 Mn 5 EN 10025 S185, S355JG3, E355 EN 10028-2 P235GH, P265GH, P295GH, P355GH EN 10028-3 P275N, P355N, P460N EN 10113-2 S355N, S460N, S500N, S500NL construction steels A-E, A 32 - E 32, A 36 - E 36					
Reference analysis (%)	C 0,07	Si 0,95	Mn 1,75			
Mechanical performance according to EN 1597-1	post-weld heat treatment U U	inert gas C M2	yield strength N/mm² 420 460	all-weld metal tensile strength N/mm² 520 560	elongation (L ₀ =5d ₀) % 24 27	energy absorbed ISO-V(Joule) 90 100
Welding position						kind of current= + inert gas (EN 439) Argon mixed gas CO²
Qualification tests and approvals	① ② WDI 16 SG: TÜV, DB ① ② VDG 16/60 • WEKO 4: TÜV, DB, ABS, DNV, GL, LR ① ② HO 3: TÜV, DB ① ② Arctron 3: 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					