

MG 3

Standards

AWS/ASME SFA - 5.18	ER70S-6
EN ISO 14341 - A	G 46 4 M21 G 4Si1
EN ISO 14341 - A	G 46 4 C1 G 4Si1
TS EN ISO 14341 - A	G 46 4 M21 G 4Si1
TS EN ISO 14341 - A	G 46 4 C1 G 4Si1

Properties and Applications

Unalloyed wire electrode for GMA (MIG/MAG) welding of general structural steels, pipes and cast steels by using CO₂ or mixed shielding gases can be used depending on thickness of the base metal. Generally used in steel construction, machine, tank, boiler production. Preheating is required, depending on the plate thickness and carbon equivalent of the base metal. A thin and homogeneous copper coating increases electrical conductivity and protects the wire from rusting.

Gas Metal Arc (MAG) Welding Wire - Non Alloyed Steels

Approvals & Certificates

DB
TUV

DNV-GL
Yerli Mali

TSE
CE

Materials

EN	DIN
S185 - P355T1	St 33 -St 52.0
S235JR - S355J0	St 37.2 - St 52.3
P235TR2 - P355T2	St 37.4 - St 52.4
P235G1TH - P265G1TH	St 35.8 - St 45.8
P235GH, P265GH	H I, H II
P295GH, P355GH	17Mn4, 19Mn5
L210 - L360NB	StE 210.7 - StE 360.7
S255N -S380N	StE 255 - StE 380
GE 200 - GE 240	GS-38, GS-45
-	A, B, D, E

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn
Welding Wire	0.06	0.9	1.7

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	C1	470	540	29	-40°C → 55
As welded	M21	480	570	28	-40°C → 55

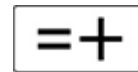
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M21 (Ar + %20 CO₂) .

Application Information

Welding Positions



Polarity:



Protection Gas:

M20 M24 M26 M21 C1

Welding Parameters & Efficiency

Diameter (mm)
0.60
0.80
1.00
1.20
1.60

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
21003ANAM2	0.60	12 KG	12.60	1	12.60	Wire Basket Spool (K300)
21003B1GM2	0.80	250 KG	257.50	1	257.50	Fiber Drum
21003B1HM2	0.80	250 KG	257.50	1	257.50	Fiber Drum
21003BAKM2	0.80	1 KG	1.10	14	15.70	Plastic Spool (D100)
21003BBAM2	0.80	5 KG	5.30	1	5.30	Plastic Spool (D200)
21003BBBM2	0.80	5 KG	5.30	1	5.30	Plastic Spool (D200)
21003BHAM2	0.80	15 KG	15.80	1	15.80	Plastic Spool (D300)
21003BJAM2	0.80	15 KG	15.70	1	15.70	Wire Basket Spool (K300MS)
21003BJHM2	0.80	15 KG	15.70	1	15.70	Wire Basket Spool (K300MS)
21003BNAM2	0.80	15 KG	15.20	1	15.20	Wire Basket Spool (K300)
21003BNHM2	0.80	15 KG	15.20	1	15.20	Wire Basket Spool (K300)
21003D0GM2	1.00	60 KG	64.00	1	64.00	Fiber Drum
21003D1GM2	1.00	250 KG	257.50	1	257.50	Fiber Drum
21003D1HM2	1.00	250 KG	257.50	1	257.50	Fiber Drum
21003DBAM2	1.00	5 KG	5.30	1	5.30	Plastic Spool (D200)
21003DBBM2	1.00	5 KG	5.30	1	5.30	Plastic Spool (D200)
21003DHAM2	1.00	15 KG	15.80	1	15.80	Plastic Spool (D300)
21003DJAM2	1.00	15 KG	15.70	1	15.70	Wire Basket Spool (K300MS)
21003DJHM2	1.00	15 KG	15.70	1	15.70	Wire Basket Spool (K300MS)
21003DNAM2	1.00	15 KG	15.20	1	15.20	Wire Basket Spool (K300)
21003DNHM2	1.00	15 KG	15.20	1	15.20	Wire Basket Spool (K300)
21003E1GM2	1.20	250 KG	257.50	1	257.50	Fiber Drum
21003E1HM2	1.20	250 KG	257.50	1	257.50	Fiber Drum
21003EBAM2	1.20	5 KG	5.30	1	5.30	Plastic Spool (D200)
21003EHAM2	1.20	15 KG	15.80	1	15.80	Plastic Spool (D300)
21003EJAM2	1.20	15 KG	15.70	1	15.70	Wire Basket Spool (K300MS)
21003EJHM2	1.20	15 KG	15.70	1	15.70	Wire Basket Spool (K300MS)
21003ENAM2	1.20	15 KG	15.20	1	15.20	Wire Basket Spool (K300)
21003ENHM2	1.20	15 KG	15.20	1	15.20	Wire Basket Spool (K300)
21003G1GM2	1.60	250 KG	257.50	1	257.50	Fiber Drum
21003GHAM2	1.60	15 KG	15.80	1	15.80	Plastic Spool (D300)
21003GJAM2	1.60	15 KG	15.70	1	15.70	Wire Basket Spool (K300MS)
21003GJHM2	1.60	15 KG	15.70	1	15.70	Wire Basket Spool (K300MS)
21003GNAM2	1.60	15 KG	15.20	1	15.20	Wire Basket Spool (K300)
21003I2GM2	2.40	400 KG	416.00	1	416.00	Fiber Drum

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.