Supramig® HD

TOP FEATURES

- Excellent feedability and very consistent welding performance
- Self releasing silicate islands
- Tight and stable arc with extremely low spatter
- Deep root penetration and improved fatigue life
- Available in all packagings from spools to drums

CLASSIFICATION

AWS A5.18	ER70S-6
EN ISO 14341-A	G42 3 C1 3Si1 / G46 4 M21 3Si1

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ >15-25% CO_2
C1	Active gas 100% CO_2

TYPICAL APPLICATIONS

- General Constructions
- Heavy Fabrication
- Infrastructures
- Automotive
- Robotics

APPROVALS

ABS	LR	BV	DNV	RINA	TÜV	DB	CWB	CE
+	+	+	+	+	+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si
0.08	1.40	0.85

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						-30°C	-40°C
Typical values	M21	AW	480	570	28		120
	C1	AW	440	550	29	70	95

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)
1.0	SPOOL (S300)	15.0
	SPOOL (B300)	16.0
	SPOOL (BS300)	16.0
	DRUM	250.0, 500.0
1.2	SPOOL (S300)	15.0
	SPOOL (B300)	16.0
	SPOOL (BS300)	16.0
	DRUM	250.0, 500.0
1.32	SPOOL (B300)	16.0
	SPOOL (BS300)	16.0
	DRUM	250.0
1.6	SPOOL (B300)	16.0
	DRUM	250.0

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.