

**MAG copper coated solid wire developed for universal use in the manufacturing of boilers and devices, as well as metalworks. Because it is suitable to be used on high currents, this wire is ideal for welding thick pieces of metal.**

## ■ Classification

AWS 5.18 : ER 70S-6

EN ISO 14341-A G42 3 M21 3Si1 EN ISO 14341-B G49A 3 M21 S12  
G42 3 C1 3Si1 G49A 3 C1 S12

## ■ Applications

- Automotive production,
- Railway construction
- Shipbuilding
- Construction.
- Tanks, boilers
- Robotics
- Production

## ■ Benefits

- Very few projections.
- High chemical purity.

## ■ Polarity

DC +

## ■ Chemical properties

C %	Mn %	Si %
0.07	1.50	0.85

## ■ Mechanical properties

Re	Rm	A 5 d	KV -30°C
≥ 420 MPa	500-640 Mpa	≥ 20%	≥ 47 J

## ■ Recommendations

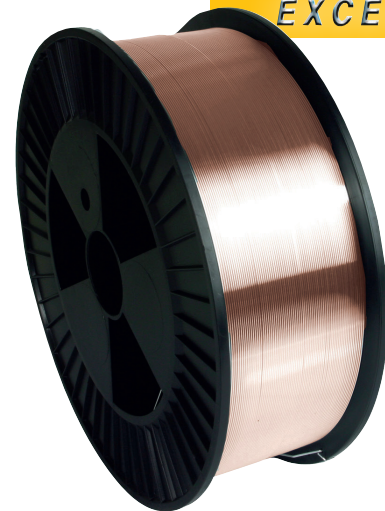
Ø wire (mm)	0.8	1.0	1.2
thickness (mm)	< 5	6 ▶ 8	8 ▶ 12
voltage (V)	16 ▶ 28	17 ▶ 32	18 ▶ 34
current (A)	60 ▶ 200	80 ▶ 260	100 ▶ 360

Gas protection complies with EN ISO 14175  
100% CO<sub>2</sub> (I1) or Argon / CO<sub>2</sub> (15 to 25%) (M21)  
or 100% CO<sub>2</sub> (C1)

## ■ Approval

TÜV - DB - CE

RANGE  
**EXCELLIUM**



## Packaging

weight (kg)	Wire reel type		Wire diameter (mm)			
			Ø 0.6	Ø 0.8	Ø 1.0	Ø 1.2
15	S300	—	—	—	086302	086319