

EN 10204

CHEMICAL
MECHANICAL

22	31
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

Number	L - 0473	Date	27.01.2011
Page	1/1		

Purchaser	SPECIALISED WELDING PRODUCTS LTD. UNITED KINGDOM		
Order Nr	11750		
Product Group	GMAW/GTAW Wire - Non & Low alloyed		
Brand Name	WELDING WIRE SG2 AWS A5.18 ER 70S-6, D300 PLASTIC SPOOL		
Standard	AWS A5.18.05 TS EN ISO 14341-A:09		
Classification	ER 70 S-6	G3Si1	
Size	1,00	mm	
Quantity	10.224,00	Kg	
Serial Nr	121571021		
Charge Nr	571-10		

Chemical Composition of Welding Wire (%)																
Charge Nr	C	Si	Mn	P	S	Cr	Ni	Mo	Cu*	V	Al	Ti+Zr	-	-	-	-
AWS	0,06 - 0,15	0,80 - 1,15	1,40 - 1,85	<0,025	<0,035	<0,15	<0,15	<0,15	<0,50	<0,03	-	-	-	-	-	-
TS/EN/ISO	0,06 - 0,14	0,70 - 1,00	1,30 - 1,80	<0,025	<0,025	<0,15	<0,15	<0,15	<0,35	<0,03	<0,02	<0,15	-	-	-	-
571-10	0,081	0,879	1,476	0,008	0,009	0,043	0,052	0,013	0,119	0,001	0,003	0,004	-	-	-	-

*Including the copper coating

Mechanical Properties										
Tensile Test					Impact Test					
- EN 10002-1					- EN 10045-1					
Specimen preparation					Specimen preparation					
- EN 876					- EN 875 VWT 0/b					
	Test Temperature	R _p Yield Strength	R _m Tensile Strength	A Elong.	Test Temperature	KV Impact Strength	KV Average	Hardness	Radiographic test	Comment
	°C	N / mm ²	N / mm ²	%L ₅₀ =5d ₀	°C	J	J	-	-	-
AWS	20	>400	>480	>22	-30	-	>27	-	-	-
TS/EN/ISO	20	>420	500 - 640	>20	-30	-	>47	-	-	-
	20	min. 420	500 - 640	min. 22	-30	-	min. 47	-	-	-



Quality Department

F186/00