

EN 10204

CHEMICAL 2.2 3.1
MECHANICAL

Number	L - 4833	Date:	13.04.2011
Page	1/1		

Purchaser	SPECIALISED WELDING PRODUCTS LTD UNITED KINGDOM		
Order Nr			
Product Group	GMAW/GTAW Wire - Non & Low alloyed		
Brand Name	SG2, COPPER FREE, MIG -D300, PLW, 15 KG NET		
Standard	AWS A5.18:05 TS EN ISO 14341-A:09		
Classification	ER 70 S-6 G3Si1		
Size	1,20 mm		
Quantity	1.080 Kg		
Serial Nr	122015141		
Charge Nr	015-11		

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	-	-	-	-	-
015-11	0,077	0,882	1,480	0,006	0,011	0,030	0,045	0,014	0,086	0,006	0,009	0,012	-	-	-	-	-

*)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	-		

Comment



Quality Department