

Standards

AWS/ASME SFA - 5.18	ER70S-3
EN ISO 14341 - A	G 38 3 M21 2Si
EN ISO 14341 - A	G 38 3 C1 2Si
TS EN ISO 14341 - A	G 38 3 M21 2Si
TS EN ISO 14341 - A	G 38 3 C1 2Si
DIN M. No.	1.5112

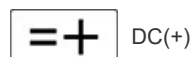
Approvals & Certificates

CE-DoP	CWB	CE
UKCA-DoP	UKCA	

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.

Welding Positions

Polarity


Protection Gas: M20 M24 M26 M21 C1

Properties

Unalloyed wire electrode for GMA (MIG/MAG) welding with CO₂ or mixed gases

Reduced slag formation; smooth weld deposit

Thin, homogeneous copper coating for good electrical conductivity and wire protection

Classified AWS ER70S-3, EN ISO 14341-A G 38 3 C1 2Si / G 38 3 M21 2Si

Applications

Welding of unalloyed steels in pipeline, boiler and tank construction

Welding of galvanized and pre-painted steels

Thin metal plate welding and repair work

Materials

EN	DIN	EN	DIN
S185 - S275T1	St 33 - St 44.0	P235GH, P265GH	H I, H II
P235G1TH - P25G1TH5	St 35.8 - St 45.8	-	A,B, D, E

Typical Chemical Features of the Welding Wire %

Type of Analysis	C	Si	Mn
Welding Wire	0.07	0.70	1.25

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	400	470	30	-30°C → 100
As welded	M21	420	520	30	-30°C → 80

* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - C1 (%100 CO₂) ve M21 (Ar + %20 CO₂) .

Welding Parameters & Efficiency

Diameter (mm)	Current (A)
0.80	50-130
1.00	110-200

Packaging Information

Product Code	Diameter (mm)	Packaging Type	Pieces per Box (~)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package
21001B0JM2	0.80	Drum	60	60.0	1	64.0
21001B1JM2	0.80	Drum	250	250.0	1	257.5
21001BAKM2	0.80	Plastic Spool (D100)	1	1.0	14	15.7
21001BHAM2	0.80	Plastic Spool (D300)	15	15.0	1	0.0
21001BJAM2	0.80	Wire Basket Spool (K300MS)	15	15.0	1	15.7
21001D1JM2	1.00	Drum	250	250.0	1	257.5
21001DBBM2	1.00	Plastic Spool (D200)	5	5.0	1	5.3
21001DHAM2	1.00	Plastic Spool (D300)	15	15.0	1	15.2
21001DJAM2	1.00	Wire Basket Spool (K300MS)	15	15.0	1	15.7
21001E1JM2	1.20	Drum	250	250.0	1	257.5
21001EJAM2	1.20	Wire Basket Spool (K300MS)	15	15.0	1	15.7
21001EJBM2	1.20	Wire Basket Spool (K300MS)	15	15.0	1	15.7
21001GJAM2	1.60	Wire Basket Spool (K300MS)	15	15.0	1	15.7

Important Safety, Technical & Customer Information

Safety Data Sheets (SDS) and all quality certificates are accessible at www.magmaweld.com, in the page footer under the QUALITY section.