



ER 70S-2 (A15)

Mild Steel WIRE/GMAW



Standards

EN/ISO-Standard - 14341-A

EN/ISO-Classification - G 42 3 M21 2Ti

AWS-Standard - A5.18

AWS-Classification - ER 70S-2

Features and Applications

- Micro-alloyed steel, triple de-oxidised (Ti, Al, Zr) suitable for the welding of C-Mn and low-alloy steels.
- Ideal for use on greasy and oxidised surfaces subsequent to any coating processes. (i.e. galvanised steel).
- Works well at low temperatures.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on tanks, containers, car industry, structural work, household appliances, pipelines, boilers, naval & petrochemical sectors etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



Approvals

CE, UKCA

Typical Base Materials

A106, A210, A234 S355J2, S380N, P235GH, GS 45, P295GH, P355GH, S355N*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Shielding Gases

EN ISO 14175 - C1, M20, M21, M33

Polarity

DC (+)

Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	60-190	80-290	120-370
Voltage (V)	18-24	18-32	18-35

Mechanical Properties (Typical)

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)	Test Temperature
560	480	24	>50	-30°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % ^a	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.06	0.60	1.20	<0.020	<0.020	<0.25	<0.10	<0.10	<0.050	0.100	<0.030	<0.15

^a (includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010202856	0.80	15	D300 PLW	72
3010202858	1.00	15	D300 PLW	72
3010202860	1.20	15	D300 PLW	72