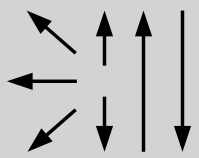


Classifications					
EN ISO 14341-A		EN ISO 14341-B	AWS A5.18		
G 35 A M23 Z2Si1		G 43A Y M23 SZ	ER70S-G [ER70S-3(mod.)]		
Characteristics and typical fields of application					
GMAW solid wire electrode for welding unalloyed and low alloy steels with shielding gas. Especially suited for electrolytically and hot-dip galvanized thin sheets. Used primarily in vehicle and autobody fabrication in conjunction with gas mixtures M12 to M23.					
Base materials					
DC01+ZE – DC04+ZE, S220GD+Z – S350GD+Z					
Typical analysis of solid wire (wt.-%)					
	C	Si	Mn		
wt-%	0.10	0.35	1.10		
Mechanical properties of all-weld metal					
Heat-treatment	Shielding gas	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
		MPa	MPa	%	+20 °C
aw	M23	360	440	25	80
Operating data					
		Polarity: DC (+)	Shielding gas: (EN ISO 14175) M12 – M23	ø mm	Spool: B300 B300 B300
				0.8	
				1.0	
				1.2	