

Weld G3Si1

A copper coated, G3Si1 solid wire for GMAW of all general structural and engineering unalloyed and low-alloyed carbon-manganese steels. The electrode may be welded with either a gas mixture or with pure CO₂ as the shielding gas.

Specifications	
Classifications	EN ISO 14341-A : G 38 2 C1 3Si1 EN ISO 14341-A : G 42 3 M21 3Si1 EN ISO 14341-A : G 3Si1 SFA/AWS A5.18 : ER70S-6
Approvals	CE : EN 13479 DB : 42.039.39 UKCA : EN 13479 VdTÜV : 13038

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Carbon-manganese steel (Mn/Si-alloyed)
Shielding Gas	M21, C1 (EN ISO 14175)

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
EN M21			
As Welded	470 MPa	560 MPa	26 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
EN M21		
As Welded	-30 °C	70 J

Typical Wire Composition %		
C	Mn	Si
0.078	1.46	0.85

Deposition Data				
Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
0.8 mm	60-180 A	18-22 V	3.2-11.0 m/min	0.8-2.6 kg/h
1.0 mm	80-250 A	18-30 V	2.7-13.0 m/min	1.0-4.8 kg/h
1.2 mm	120-330 A	18-34 V	2.3-13.0 m/min	1.3-6.9 kg/h

Welding Parameters
Wire Diameter
1.6 mm