

ES MIG 70S-3

GMAW
ER70S-3

ESWECO
The Art of Welding

Description

ES MIG 70S-3 is a copper-coated, Mn-Si- alloyed G2Si/ER70S-3 solid wire for the GMAW of non-alloyed steels, as used in general construction, pressure vessel fabrication and shipbuilding. The wire has a carefully controlled wire chemistry and a unique surface technology providing superior weld-metal quality at high wire feed speeds and at high welding currents. The wire can be used with both Ar/CO₂ mixed gas and pure CO₂ shielding gas.

Current

DC+

Classifications

SFA/AWS A5.18	ER70S-3
EN 440	G2Si

Typical all weld metal composition, %

C	Si	Mn
0.1	0.6	1.1

Typical mech. Properties all weld metal

Yield stress, MPa	420
Tensile strength, MPa	515
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
+20	140
-20	110
-30	90

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V
0.8	3-12	70-250	18-24
1.0	2.7-15	80-300	18-32
1.2	2.5-15	120-380	18-34