

SupraMig Ultra®

CLASSIFICATION

AWS A5.18	ER70S-6	A-Nr	1	Mat-Nr	1.5130
EN ISO 14341-A	G46 3 C 4Si1 / G50 5 M 4Si1	F-Nr	6		
		9606 FM	1		

GENERAL DESCRIPTION

Solid wire with increased manganese for semi-automatic welding and robotic applications
 Excellent feedability and very consistent welding performance
 Tight and stable arc with extremely low spatter
 Also provided in Accutrak® drum

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu



PG/3Gd

SHIELDING GASES (ACC. ISO 14175)

M21	Mixed gas Ar+ >15-25% CO ₂
C1	Active gas 100% CO ₂

APPROVALS

ABS	BV	DNV/GL	RINA	LR5	DB	TÜV	CE	CWB
+	+	+	+	+	+	+	+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si
0.08	1.70	0.85

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength [N/mm ²]	Tensile strength [N/mm ²]	Elongation [%]	Impact ISO-V(J)		
						-20°C	-40°C	-50°C
Typical values	M21	AW	500	650	26	80	80	70
	C1	AW	490	620	30	60	50	

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
General structural steels	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 to DH36
Cast steels	EN 10213-2	GP240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
Boiler & pressure vessel steels	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	EN 10025 part 3	S275, S355, S420, S460
	EN 10025 part 4	S275M, S275ML, S355M, S355ML, S420M, S420ML, S460, P460, S460ML

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2	1.4	1.6
16 kg spool B300	X	X	X	X	X
16 kg spool B5300		X	X		
15 kg spool S300		X	X		
250 kg Accutrak® Drum		X	X	X	
500 kg Accutrak® Drum		X	X	X	

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