

CF3 - G4Si1 (Copper Free)

Mild Steel WIRE/GMAW

Standards

EN/ISO-Standard - 14341-A

AWS-Standard - A5.18

EN/ISO-Classification - G 42 3 C1 / G 46 4 M21 4Si1

AWS-Classification - ER 70S-6

Features and Applications

- A non-copper coated solid wire suitable for single pass or multipass welding of unalloyed and low-alloyed carbon-manganese steels.
- Environmentally friendly when compared against traditional copper wires offering less fume and smoke in the working environment.
- The higher Si-Mn content increases the weld metal strength and leaves a good bead appearance.
- Designed for semi-automatic and full-automatic GMAW applications.
- Good mechanical properties at sub-zero temperatures down to -40°C.
- Vacuum-sealed plastic bag packaging to prevent moisture absorption.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on boilers, industrial machinery, bridges, shipbuilding, automotive, rail, structural and engineering fabrications.
- 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**



Typical Base Materials

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML, S460, P460, S460ML*

* Illustrative, not exhaustive list

Welding Positions

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

Shielding Gases

EN ISO 14175 - C1, M21

Polarity

DC (+)

Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu %	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.08	0.95	1.70	<0.020	<0.020	0.010	<0.15	<0.15	<0.050	<0.020	<0.030	<0.15

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010201314	0.80	15	BS300 PLW	72
3010201316	1.00	18	BS300 PLW	56
3010201318	1.20	18	BS300 PLW	56

Drums also available.

Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	60-200	80-300	120-380
Voltage (V)	18-24	18-32	18-34

Mechanical Properties (Typical) - C1

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)	Test Temperature
570	460	36	58	-30°C

Mechanical Properties (Typical) - M21

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)	Test Temperature
590	490	28	88	-40°C

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

Liability: Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.



Exclusive Partnership



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