

# FILCORD D

## MIG/MAG solid wires-TIG rods

C-Mn and low-alloy steels

SAF-FRO

FILCORD D is a copper coated G4Si1/ER70S-6 type solid MAG welding wire supplied precision layer wound, depositing C-1.3%Mn weld metal, for welding a wide range of mild and C-Mn structural steels. Suitable for welding with CO<sub>2</sub> and Ar-based mixed shielding gases.

FILCORD D is a general application welding wire electrode used for both single- and multipass welding. Weld metal impact toughness properties are down to -40°C.

FILCORD D is available with a wide range of packaging formats, from few kgs for small MIG/MAG welding equipments to high-quantity (max. 500 kgs drum) robotic application. The increased level of Manganese and Silicon scavenge oxides enhancing weld pool fluidity and stabilizing the arc, minimising weld metal spatter and resulting in a higher strength weld metal. Excellent weld bead appearance with an even contour finish and freedom from undercut.

Solid coppered wire to use with CO<sub>2</sub> or Ar/CO<sub>2</sub> Mix shielding. Suitable for metal structures, earthmoving machinery. Layer wound solid wire supplied on ecological spools.

Classification	
EN ISO	14341-A: G 46 3 C1 4Si1
EN ISO	14341-A: G 46 4 M21 4Si1
AWS	A5.18: ER 70S-6

Approvals				
ABS	DB	GL	LRS	TÜV
3YSA	●	3YS	3YS H15	●

CE

### Chemical analysis (Typical values in %)

		C	Mn	Si	P	S
Wire	-	0.07	1.7	0.9	≤ 0.025	≤ 0.025
All weld metal	82% Ar+18% CO <sub>2</sub>	0.08	1.3	0.7	≤0.025	≤0.025
All weld metal	100% CO <sub>2</sub>	0.08	1.2	0.6	≤0.025	≤0.025

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Impact Energy ISO - V (J)		
				+20 °C	-30 °C	-40 °C
As Welded (*)	≥460	550-680	≥24	≥100	≥80	≥70
As Welded (**)	≥460	550-680	≥24	≥80	≥47	

Gas test: (\*) 82% Ar+18% CO<sub>2</sub>, (\*\*) 100% CO<sub>2</sub>

**Shielding Gas** - EN ISO 14175 : C1, M14, M2, M3

### Materials

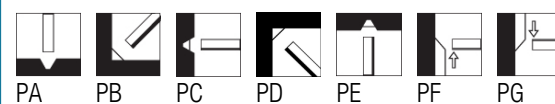
S(P)235 - S(P)460; GP240; GP280

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



# FILCORD D

MIG/MAG solid wires-TIG rods

*C-Mn and low-alloy steels*



## Packaging data

Packaging Type	B300	BS300	S300
Diam(mm) / weight(kg)	16	16	15
0.8	W000282741	W000289156	W000282739
0.9	W000282747		
1.0	W000282755		