

ULTRAFIL 1A is a copper coated G4Si1/ER70S-6 type solid MAG welding wire used for welding a wide range of mild and C-Mn structural steels. Suitable with CO₂ and Ar-based mixed shielding gases.

ULTRAFIL 1A is a general application welding wire electrode used for both single- and multipass welding.

Solid coppered wire to use with CO₂ or Ar/CO₂ Mix shielding gas. Suitable for metal structures, earthmoving machinery.

Classification		Approvals	Grade
EN ISO	14341-A: G 46 3 C1 4Si1	DB	●
EN ISO	14341-A: G 46 4 M21 4Si1	TÜV	●
AWS	A5.18: ER 70S-6	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 (*)	0.08	1.3	0.7	≤ 0.025	≤ 0.025
All weld metal (**)	0.08	1.2	0.6	≤ 0.025	≤ 0.025

(*) 82% Ar+18% CO₂, (**) 100% CO₂

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)		
				+20 °C	-30 °C	-40 °C
As Welded (*)	≥460	530-680	≥24	≥100	≥80	≥70
As Welded (**)	≥460	530-680	≥24	≥80	≥47	

Gas test: (*) 82% Ar+18% CO₂, (**) 100% CO₂

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+

