

MIG/MAG solid wires-TIG rods Mild and low-alloy steels

ULTRAFIL 1 is a copper coated G3Si1/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 1 is a welding wire electrode used for general applications in both single- and multipass welding.

Solid wire with good mechanical characteristics to weld non-alloy steels. Used under CO₂ or Mix shielding gases.

Classification	Approvals	Grade
EN ISO 14341-A: G 42 3 C1 3Si1	DB	●
EN ISO 14341-A: G 42 4 M21 3Si1	TÜV	●
AWS A5.18: ER 70S-6	CE	

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S
Wire	0.08	1.5	0.9	≤ 0.025	≤ 0.025
All weld metal (*)	0.08	1.1	0.6	≤ 0.025	≤ 0.025
All weld metal (**)	0.09	1.0	0.5	≤ 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 (*)	≥ 420	500-640	≥ 24	≥ 90	≥ 70	≥ 47
As Welded (**)	≥ 420	500-640	≥ 22	≥ 70	≥ 47	

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

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

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+

