

# SupraMig® HD

## CLASSIFICATION

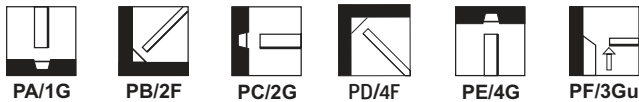
AWS A5.18	ER70S-6	A-Nr	1	Mat-Nr	1.5125
EN ISO 14341-A	G 46 4 M 3Si1 / G 42 3 C 3Si1	F-Nr	6		
		9606 FM	1		

## GENERAL DESCRIPTION

Solid wire for welding of structural steels  
Excellent feedability and very consistent welding performance  
Self releasing silicate islands

Tight and stable arc with extremely low spatter  
Deep root penetration and improved fatigue life  
Ultimate GMAW wire for heavy duty high deposition applications

## WELDING POSITIONS (ISO/ASME)



## SHIELDING GASES (ACC. ISO 14175)

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

## APPROVALS

ABS	BV	DNV	GL	LR	TÜV	CE	DB
+	+	+	+	+	+	+	+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si
0.08	1.40	0.85

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)	
						-30°C	-40°C
Typical values	M21	AW	502	574	28		102
	C1	AW	486	570	29	71	

## 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
	EN 10025 part 4	S275M, S275ML, S355M, S355ML, S420M, S420ML, S460

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2	1.6
15 Kg spool B300	X	X	X	X
15 Kg spool BS300	X	X	X	X
15 kg spool S300	X	X	X	X
250 kg Accutrak® Drum	X	X	X	
500 kg Accutrak® Drum	X	X	X	X
Other sizes and packaging on request				

Supramig® HD :rev. C-EN04-01/02/16

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.  
Fumes: Safety Data Sheets (SDS) are available on our website.