

Gold G3Si1

Marking according to standards: EN ISO 14341-A: G 42 4 C1/ M21 3Si1,
SFA / AWS A5.18: ER 70 S-6

Manganese-silicon, copper Electrode Wire for MIG/MAG welding of low carbon
and unalloyed steel

General description:

GOLD G3Si1 copper Electrode Wire for MIG/MAG welding in all positions.
Shielding gas: CO₂ or Ar+ CO₂.

Welding positions:



Current type:

DC+

Gas flow:

14 – 20 l/min

Welded metal typical chemical composition

C	Si	Mn	P	S
0.10	0.90	1.45	0.010	0.010

Welded material

P235/ S 235 to P 460/ S 460 and other steel types

Typical mechanical properties

Limit of yield [N/mm ²]	Limit of strength [N/mm ²]	Elongation [%]	Impact strength [J] -40°C
460	560	30	Min 47 J

Recommended welding parameters (DC+)

Diameter of wire [mm]	Welding current [A]	Arc voltage [V]	Gas flow [l/min]	Wire feeding [m/min]	Metal yield [kg/h]
0,80 mm	60 - 185	18 - 24	14	3,2 - 10	0,8 - 2,5
1,00 mm	80 - 300	18 - 32	16	2,7 - 15	1,0 - 5,5
1,20 mm	120 - 380	18 - 35	18	2,3 - 15	1,2 - 8,0
1,60 mm	120 - 380	18 -35	20	2,3 - 15	1,2 - 8,0

Approvals:

TUV (10841.07), DB (42.078.01), LR, ABS, CWB, RMRS

Packaging method:

0.8-1.6 mm 15 kg & 5 kg spools, 250 kg barrels