



ESAB MW1

ESAB MW1 is a copper coated, Mn-Si alloyed solid wire for MIG/MAG welding of non alloyed steels, used in automotive, general construction, ship building etc. The wire has a carefully controlled wire chemistry and an unique surface technology that provides superior weld metal quality at high wire feed speeds.

Classifications Weld Metal:	EN ISO 14341-A:G 42 3 C1 3Si1, EN ISO 14341-A:G 42 3 M21 3Si1
Classifications Wire Electrode:	EN ISO 14341-A:G 3Si1, SFA/AWS A5.18:ER70S-6
Approvals:	DNV III MS/IIIT, IBR ER70S6, IRS 2M, 1T, LR 1T, 3S, RDSO Class I

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type:	Mn-Si alloyed
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 Shielding gas			
As Welded	430 MPa	530 MPa	26 %
M21 Shielding gas			
As Welded	450 MPa	560 MPa	23 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 Shielding gas		
As Welded	-30 °C	70 J
M21 Shielding gas		
As Welded	-30 °C	80 J

Typical Wire Composition %

C	Mn	Si
0.075	1.45	0.85

Current Range

Diameter	Current	Voltage
0.8 mm	60-200 A	17-24 V
1.2 mm	120-330 A	18-30 V
1.6 mm	225-440 A	28-36 V
2.0 mm	300-550 A	32-41 V