



**TECHNICAL DATA SHEET NOVOFIL 70 SPECIAL BRONZE WIRES**

Classification of the material according to the international spec.

AWS A5.18: ER70S-6  
 DIN 8559: SG2  
 ISO 14341-A (2011) G 42 4 M21 G3 SI 1

Welding wires to be used for both Co2 / M2x-M3x mixed combination gases The wire is specially coated by a bronze film. Available from sizes 0,80 to 1.60mm on spools 1/kg-25/kg and megapacks 80/kg-450/kg

**Materials :** St. 37 – St 52, *HI – III*, 17 Mn 4, steel St 35 , St. 35.8, St. 45.8, SIE 420.

**Typical chemical content ( %)**

<i>C</i>	<i>Mn</i>	<i>Si</i>
0.07-0.09	1.40-1.50	0.80-0.90

**Mechanical properties of welded material as per DIN 32 525 ( min.)**

Tested in laboratory in accordance to UNI EN ISO 148-1:2011

<b>Tensile Strength</b> : (N/mm <sup>2</sup> )	> = 540	CO2/M21
<b>Yield strength</b> : (N/mm)	> = 460	CO2/M21
<b>Elongation</b> : (A 5 %)	27 – 32	CO2/M21

**RECOMMENDED  
WELDING  
PARAMETERS**

DIAMETER WIRE	SHORT	ARC	SPRAY	ARC
MM	AMPERE	VOLT	AMPERE	VOLT
0,80	80-130	18-20	170-250	23-28
0,90	130-170	18-22	180-260	24-29
1,00	140-180	18-25	220-280	24-29
1,20	140-200	18-25	320-370	26-29
1,40	140-200	18-25	350-400	26-30
1,60	140-200	18-25	380-420	26-30

The used gas is M 21 ( 80% Argon - 20% Co2) - Including 92%Ar – 8%CO2

<b>Power type : DC+</b>	<b>Wire speed: 12-15mts/min</b>	<b>Gas: 12-14 lt/minute</b>
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