

# 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 and ship building. The wire has a carefully controlled wire chemistry and a unique surface technology providing superior weld metal quality at high wire feed speeds.

<b>Classifications Weld Metal</b>	EN ISO 14341-A : G 42 3 C1 3Si1 EN ISO 14341-A : G 42 3 M21 3Si1
<b>Classifications Wire Electrode</b>	SFA/AWS A5.18 : ER70S-6 EN ISO 14341-A : G 3Si1
<b>Approvals</b>	ABS 3SA 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.

<b>Alloy Type</b>	Mn-Si alloyed
<b>Shielding Gas</b>	M21, C1 (EN ISO 14175)

## Typical Tensile Properties

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

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>M21 Shielding gas</b>		
As Welded	-30 °C	80 J
<b>C1 shielding gas</b>		
As Welded	-30 °C	70 J

## Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
0.075	1.45	0.85	0.015	0.020	0.01	0.03	0.01	0.01	0.01

## Typical Wire Composition %

Cu	Ti+Zr
0.30	0.05