

Classifications					
EN ISO 17632-A		AWS A5.18 / SFA-5.18		AWS A5.36 / SFA-5.36	
T3T Z M M21 1		E70C- GS		E70TGS-M21-GS	
Characteristics and typical fields of application					
Cored wire for single layer welding of galvanized, zinc coated or thin painted sheets (0.8 – 4 mm). It offers a good weldability, excellent bead appearance and low spatter formation. The main applications are for air condition systems, general constructions with galvanized steels and automotive industry.					
Base materials					
Galvanized steel sheets					
Typical analysis					
	Gas	C	Si	Mn	Al
wt.-%	M21	0.30	0.30	1.10	1.80
Mechanical properties of all-weld metal - typical values (min. values)					
Condition	Yield strength R_e		Tensile strength R_m		Elongation A ($L_0=5d_0$)
	MPa		MPa		%
u	≥355		≥ 490		-
u - untreated, as welded – shielding gas M21					
Operating data					
Polarity	DC-		Dimension mm		
Shielding gas (EN ISO 14175)	M21; M20; (Ar + 5 – 25% CO ₂)		1.0		
			1.2		
Welding with standard GMAW power source possible					
Approvals					
CE					