

# AX-WSG2 1.5125

## Standard

EN ISO 636-A	W 3Si1 (Wire)
EN ISO 636-A	W 42 5 W3Si1 W3Si1
EN ISO 636-B	W49A 5U W6
Material number	1.5125
AWS A5.18	ER70S-6

## Area of application

Filler rod for joints on unalloyed and low-alloyed steels in boiler, tank, machinery and vehicle construction.

## Special hints

## Composition of the filler rod (typical data in %)

C	Si	Mn					
0.1	0.85	1.45					

## Important base materials

S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S420N, S275M-S420M, S275NL-S420NL, S275ML-S420ML, P235GH-P355GH, P275NL1-P355NL1, P275NL2-P355NL2, P215NL, P265NL, P355N, P285NH-P420NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L245MB-L415MB, GE200-GE240  
 ASTM A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 283 Gr. B, C, D; A 350 Gr. LF1; A 501 Gr. B; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 60, 65, 70; A 572 Gr. 42; A 633 Gr. A, C, D; A 662 Gr. A, B, C; A 678 Gr. B; A 707 Gr. L1, L3; A 709 Gr. 36, 50; A 711 Gr. 1013; A 841 Gr. A, B, C; API 5 L B, X42, X52, X60

## Material properties

Welding process	TIG	Mechanical properties of the weld metal according to EN ISO 15792-1	
Shielding gas	argon I1		
Test temperature	20°C		
0.2%-yield strength $R_{p0.2}$	[MPa]		430
Tensile strength $R_m$	[MPa]		560
Elongation A ( $L = 5d_0$ ) %	[%]		24
Impact strength $A_v$	[J]		90

## Applicable shielding gases (EN ISO 14175)

TIG: argon I1

## Approvals

(Request current scope if required)

## Product forms

Rod	Ø mm x 1000 mm	1.6	2.0	2.4	3.0		
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