



HILCO K60

MAG wires – unalloyed steel

AWS A5.18: ER 70S-6

EN ISO 14341-A: G 38 2 C G3 Si 1 / G 42 3 M G3 Si 1

Wire type:
MAG Solid wire

Current:



Welding positions:



Shielding gas:
C1, M1-M3

K60 is our solid wire for MAG welding unalloyed and low alloyed, incl. fine grain types, structural steels. The wire is used in a wide range of applications: general constructions, shipbuilding, bridges, tanks etc.

Base materials to be welded:

- Ships plate A-E, A(H)32-E(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2G3, St.33-St.52.3, C(K)10-C(K)35
- Boiler steel P235GH-P355GH, HI, HII, 17Mn4, 19Mn6
- Fine grain steel P275N-P355NL2, S275N-S420N, StE285-ESStE355, StE285TM-ESStE355TM
- Pipe steel P235T1-P355N, L210-L415MB, St37.0-St52.4, St45.8, X42-X60, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

Applications:

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance
- Transport & Lifting Industry

Chemical composition of the welding wire – typical:

C	Mn	Si	S	P
0,07	1,50	0,90	≤ 0,025	≤ 0,025

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 420	≥ 500	≥ 22	-30°C ≥ 27

Packaging and welding data:

Dia. mm.	Spool type	Weight / spool kg.	Current A	Voltage V
0,6	S200 vac	5	60-140	16-20
0,8	S200 vac	5	80-180	17-20
0,8	S300 vac	15	80-180	17-20
0,9	S300 vac	15	100-200	17-20
1,0	S300 vac	15	120-240	17-22
1,2	S300 vac	15	160-260	18-26
1,6	S300 vac	15	180-300	20-29