

# PRODUCT DATA SHEET

## MIG/TIG 13.7



MIG/TIG 13.7 is a solid wire, designed for welding mild and low alloy steels, particularly killed steels.

### Classifications (MIG)

AWS	A5.5	ER 70S-3
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### Typical Chemical Analysis (All weld metal)

% Carbon	0,07	% Sulphur	0,012
% Manganese	1,2	% Phosphorous	0,012
% Silicon	0,6	% Copper	0,12

### Typical Mechanical Properties (All weld metal in the as welded condition)

Yield Strength	420 MPa	450 MPa
Tensile Strength	530 MPa	560 MPa
% Elongation	28	28
Charpy V-Notch at +20°C	130 J	140 J
Charpy V-Notch at 0°C	90 J	90 J
Charpy V-Notch at -20°C	70 J	60 J

### Packing Data MIG (DC+)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
0,8	120	17	15,0	W078392
1,2	280	26	15,0	W078387

### Packing Data TIG (DC-)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	(A)	(V)		
1,6	100	12	5,0	W078388
2,4	100	12	5,0	W078389

Suggested shielding gases: Argoshield® 5 (MIG), Argon (TIG)

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