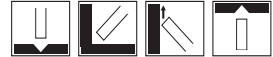


# Solid Wires

Non Alloyed MAG Spooled Wire

## Bostrand LW3



### Classification Weld Metal

EN ISO 14341-A G 42 2 C G4Si1  
EN ISO 14341-A G 46 3 M G4Si1

### Classification Wire Electrode

EN ISO 14341-A G4Si1  
SFA/AWS A5.18 ER70S-6

### Description and applications

Bostrand LW3 is a general purpose mild steel copper coated MAG wire. De-oxidised with manganese and silicon, it produces quality welds with excellent radiographic and mechanical properties. Bostrand LW3 is ideal for welding most mild and carbon-manganese where an increased strength over LW1 is required.

### Chemical Composition

	All Weld Metal (%)		Wire/Strip (%)	
	EN 80Ar/20CO <sub>2</sub> (M21) CO <sub>2</sub> (C1)		Min	Max
	Nom	Nom		
C	0.10	0.09	0.06	0.14
Si	0.80	0.70	0.80	1.15
Mn	1.28	1.08	1.60	1.85
P	0.013	0.013		0.025
S	0.013	0.013		0.025

### Mechanical Properties of Weld Metal

Properties	AWS C02 (C1)	EN 80Ar/20CO <sub>2</sub> (M21)			EN 80Ar/20CO <sub>2</sub> (M21)		EN 80Ar/20CO <sub>2</sub> (M21)		EN C02 (M21)			
	As welded	As welded 920°C 0.5h			Normalized 920°C 0.5h		Normalized 620°C 15h		Strell relieved		As welded	
	Min	Min	Max	Typ	Typ	Typ	Typ	Typ	Typ	Min	Max	Typ
Rp0.2 (MPa)	400	-	-	-	-	-	-	-	-	-	-	-
ReL (MPa)	-	460	525	320	320	385	385	385	385	420	-	475
ReH (MPa)	-	-	-	535	330	330	395	395	395	485	-	-
Rm (MPa)	480	530	680	595	465	465	520	520	520	500	640	570
A4-A5 (%)	22	20	-	26	32	32	28	28	28	20	-	25
Z (%)	-	-	-	68	71	71	73	73	73	-	-	70
Charpy V at -20°C (J)	-	-	-	130	100	100	120	120	120	-	-	110
Charpy V at -20°C (J)	-	90	-	-	75	75	90	90	90	47	-	70
Charpy V at -29°C (J)	27	-	-	-	-	-	-	-	-	-	-	-
Charpy V at -30°C (J)	-	47	-	70	-	-	-	-	-	-	-	-

### Welding Parameters

Size (mm) 0.8 1.0 1.2  
Current (amps) 60-200 80-300 120-380