

## Purus 46

A copper coated G4Si1/ER70S-6 solid wire for GMAW of carbon-manganese steels. Purus 46 is particularly suited to be used in general construction, automotive components and mobile machinery industries. It has a slightly higher manganese and silicon content than Purus 42 to increase the weld metal strength. The wire may be welded with either a gas mixture or with pure CO<sub>2</sub> as shielding gas. Purus 46 is designed to give a clean weld bead with a minimum of silica islands and spatter. The wire is suitable for robotic applications at high deposition rates.

<b>Classifications Weld Metal:</b>	EN ISO 14341-A: G 42 3 C1 4Si1, EN ISO 14341-A: G 46 4 M21 4Si1, EN ISO 14341-A: G 46 4 M20 4Si1
<b>Classifications Wire Electrode:</b>	SFA/AWS A5.18: ER70S-6, EN ISO 14341-A: G 4Si1
<b>Approvals:</b>	CE EN 13479, VdTÜV 19261

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type:</b>	Carbon-manganese steel (Mn/Si-alloyed)
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS CO<sub>2</sub> (C1)</b>			
As welded	450 MPa	560 MPa	29 %
<b>EN 80Ar/20CO<sub>2</sub> (M21)</b>			
As welded	475 MPa	585 MPa	26 %
<b>EN 92Ar/8CO<sub>2</sub> (M20)</b>			
As welded	500 MPa	600 MPa	25 %
<b>EN CO<sub>2</sub> (C1)</b>			
As welded	450 MPa	560 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
<b>AWS CO<sub>2</sub> (C1)</b>		
As welded	-30 °C	70 J
<b>EN 80Ar/20CO<sub>2</sub> (M21)</b>		
As welded	20 °C	130 J
As welded	-30 °C	70 J
As welded	-40 °C	60 J
<b>EN 92Ar/8CO<sub>2</sub> (M20)</b>		
As welded	-30 °C	90 J
As welded	-40 °C	80 J
<b>EN CO<sub>2</sub> (C1)</b>		
As welded	20 °C	120 J
As welded	-30 °C	70 J

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## Typical Wire Composition %

C	Mn	Si
0.08	1.65	0.90

## Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	60-200 A	18-24 V	3.2-10 m/min	0.8-2.3 kg/h
0.9 mm	70-250 A	18-26 V	3.0-12 m/min	0.9-3.5 kg/h
1.0 mm	80-300 A	18-32 V	2.7-15 m/min	1.0-5.5 kg/h
1.14 mm	100-350 A	18-34 V	2.6-15 m/min	1.2-7.0 kg/h
1.2 mm	120-380 A	18-35 V	2.5-15 m/min	1.3-8.0 kg/h
1.32 mm	130-400 A	19-35 V	2.4-15 m/min	1.5-8.5 kg/h
1.4 mm	150-420 A	22-36 V	2.3-12 m/min	1.6-8.7 kg/h
1.6 mm	225-550 A	28-38 V	2.3-10 m/min	2.1-9.4 kg/h