

Coromig 58

Classifications Weld Metal

SFA/AWS A5.18	E70C-6C
SFA/AWS A5.18	E70C-6M
EN ISO 17632-A	T 42 2 M C 1 H10
EN ISO 17632-A	T 42 2 M M 1 H10

Description and applications

Coromig 58 is a metal-cored wire which has been developed for use with both CO₂ and Ar/CO₂ shielding gases. The wire is suitable for general mild steel welding applications for parent material thicknesses over 5mm.

With CO₂ shielding gas, the wire is particularly recommended for single run fillets using spray transfer in the flat, horizontal-vertical and vertical-down positions. Ar/CO₂ mixed gas is preferred for multi-run fillets and butts in the flat and horizontal-vertical positions, and for overhead. Dip transfer conditions must be used for vertical-up welding. Low slag levels and minimal spatter make Coromig 58 ideal for robotic welding.

Approvals

CE EN 13479

Typical all-weld mechanical properties under shielding gas of 80 Ar/20 CO₂

Composition Wt %			Mechanical	As welded
	Min	Max		
C	0.04	0.11	YS	420 min N/mm ²
Si	0.35	0.85	UTS	510-640 N/mm ²
Mn	1.05	1.65	Elongation	22 min %
S		0.025	CVN at -20°C	54 min ave J
P		0.025		
Hydrogen		< 10ml/100g		
Current range	DC + or - with 15-20 l/min Ar/20%CO ₂		DC - with 15-20 l/min CO ₂	
Size (mm)	1.2	1.6		
Current (amps)	100-320	140-450		