

WAAM solid wire, unalloyed, structural steel

Material Type

S355	10Mn4	1.1108
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Characteristics

WAAM solid wire designed for 3Dprinting of unalloyed steel structures.
The printed deposit is characterised by a low Mn and Si content.

Typical analysis of the solid wire (wt.-%)

	C	Si	Mn
wt.-%	0.10	0.3	1.05

Available products

Diameter: 1,0 mm – 1,2 mm
Package: BS300 15 kg – ECOdrum 100 – ECOdrum 250 – S760 300
Other diameters and packages on request.

Typical mechanical properties acc. to EN ISO 15792-1

Heat treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation (L ₀ =5d ₀)	Impact energy ISO-V KV J
	MPa	MPa	%	-20 °C
u	420	500	25	75

u untreated, shielding gas Ar + 18 % CO₂

Classification as welding consumable:

EN ISO 14341-A	AWS A5.18
G 35 2 M21 Z2Si	ER70S-G