

WAAM solid wire, low-alloyed, high strength structural steel

Material Type	
S620	10MnNiMoSi6-4-4

**Characteristics**  
 WAAM solid wire designed for 3Dprinting of fine grained steel structures with high yield strength. Good low temperature toughness.

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

	C	Si	Mn	Ni	Mo
wt.-%	0.10	0.65	1.55	1.10	0.40

**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 of all-weld-metal EN ISO 15792-1**

Heat treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation (L <sub>0</sub> =5d <sub>0</sub> )	Impact energy ISO-V KV J
	MPa	MPa	%	-40 °C
u	620	700	18	65
u untreated, shielding gas Ar + 18 % CO <sub>2</sub>				

Classification as welding consumable:

<b>EN ISO 16834-A</b>	<b>AWS A5.28</b>
G 62 5 M21 Mn3Ni1Mo	ER90S-G