

## GENERAL DESCRIPTION

ELITE 805 wire is a premium precision wound wire recommended for welding of mild and medium strength steels.

A coated surface with a base of BRONZE film, which will give a clear weld bead and minimise spatter and supports the reduction of contact tip and guide roller consumption and an evident reduction of welding fumes. ELITE 805 releases a clearer weld bead compared to standard copper wire and the exclusive manufacturing process allows the surface of the wire to stay very compact and clean.

The wire is designed for both single and multiple pass welding in all positions.

### APPLICATIONS:

- General steel construction
- Pressure Vessel Fab
- Structural Welding
- Sheet metal applications
- Pipe welding
- Robotic welding

## WELDING POSITIONS



## CLASSIFICATION

AS/NZS ISO 14341-B-G 49A 3U C S6, G 49A 3U M S6

AWS/ASME-SFA A5.18/5.18M ER70S-6

## RECOMMENDED SHIELDING GASES

ISO 14175 : C1

ISO 14175 : M21

## CHEMICAL COMPOSITION

Wt% -	C	Si	Mn
wire	0.07	0.85	1.45

## TYPICAL MECHANICAL PROPERTIES

Typical as welded	ISO 14175 : M21	ISO 14175 : C1
Yield Strength	452MPa	420MPa
Tensile strength	560MPa	525MPa
Elongation	27.0%	31%
Impact Energy CVN	84J/ -30° C	72J/ -30° C

## WELDING PARAMETERS (DC+)

	0.9mm Ø	1.0mm Ø
Current (A)	90 - 220	80 - 250
Voltage (V)	16 - 30	17 - 30

Welding parameters are a guide only as they are dependent on the machine used / setup parameters, material thickness and operator experience. Some adjustments between wire types would be needed as Euromarc 841 is melting from lower amperage vs some competitor brands.

No data is to be construed as a recommendation for any welding condition or technique by Euromarc.

## CONFORMANCE AND APPROVAL

CE, LR, ABS, TUV, DNV

## STORAGE

Store all wire spools in their original packaging in a controlled environment of less than 50% relative humidity.

## WARNING

Electric shock can kill. Arc rays can injure eyes. Welding fumes are hazardous to your health and may damage lungs and other organs. Use adequate ventilation. Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection.

Read and understand the Safety Data Sheet for this product.

## PACKAGING INFORMATION

Size	Weight	Spool	Vacuumed Packed	Part Number / Order code
0.9	15kg	D300	YES	VW80500915
1.0	15kg	D300	YES	VW80501015