



Nexus A15/A18

Mild Steel wires for TIG welding applications

Mild Steel copper coated solid wires for TIG welding, mild and medium tensile steel tubes. A15 is triple deoxidised wire for improved single pass welding on rusty and mill scaled plate.

International Standards

	BS EN ISO 1668:1997	AWS A5.18-01
A15	W 46 2 2Ti	ER70S- 2
A18	W 46 2 3Si1	ER70S- 6

Typical Wire Analysis (wt%)

	C	Si	Mn	S	P	Al	Ti	Zr
A15	0.05	0.55	1.20	<0.025	<0.025	0.10	0.10	0.07
A18	0.09	0.87	1.47	<0.025	<0.025	-	-	-

Typical All-Weld Metal Mechanical Properties

	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact Strength
A15	≥480	≥560	≥22	≥47J@-20°C
A18	≥420	≥500	≥22	≥47J@-50°C

Welding Positions

All Positions including vertical down

Materials

A15	S255N-S380N, P235GH-P265GH, P295GH P355GH
A18	S185-P275JR, S355JO-E335, S255N-P355N, P235GH, P265GH, P310GH

Packaging

Size mm	1.6	2.4	3.2
Plastic 5 kilo Tube	✓	✓	✓

Additional Information

Certification	BS EN 10204:2004 Type 3.1
Material safety data sheet	MSDS 01
BOC Shielding Gas	Pureshield Argon
Related Nexus Products	MIG Nexus SG2/SG3, Electrodes Nexus E6013/E7024