

G1

CATEGORY Oxi-Acetylene welding

TYPE Copper-coated unalloyed rod for gas welding.

APPLICATIONS Gas welding of unalloyed steels with a minimum tensile strength of 340 MPa. Mainly used for welding plates, pipes and other profiles with low strength required.

PROPERTIES Joints are homogenous and soft, the mechanical treatment is very good.

CLASSIFICATION

AWS	A 5.2: R 45
EN ISO	12536: O1
DIN: W.Nr.	1.0324
DIN	8554: G1

SUITABLE FOR St33, St52, St35, St35.8, 1.0035, 1.0561, 1.0308, 1.0305

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si
< 0.10	0.50	< 0.20

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				+20°C	+40°C	+60°C	
AW	> 260	360-450	> 20	> 35			100-200

AW: as welded

WELDING PARAMETERS / PACKING

Sizes		Welding Parameters	Packing
D (mm)	Length (mm)	Flame type	kg / tube / carton
1.6	1000	Neutral to reducing	5 / 25
2.0	1000	Neutral to reducing	5 / 25
3.0	1000	Neutral to reducing	5 / 25
4.0	1000	Neutral to reducing	5 / 25
5.0	1000	Neutral to reducing	5 / 25
6.0	1000	Neutral to reducing	5 / 25

REDRYING TEMPERATURE not required