

G3

CATEGORY Oxi-Acetylene welding

TYPE Copper-coated unalloyed rod for gas welding (0,5% Ni)

APPLICATIONS Gas welding of unalloyed steels

CLASSIFICATION
 AWS AWS A5.2: R60
 EN ISO EN 12536: O3
 DIN: W.Nr. 1.6215
 DIN DIN 8554: G3

SUITABLE FOR S 235G2T-S255GT, S235JO-S275JO, P235G1TH, P255G1TH, P235GH, P265GH, P285NH, P295GH

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Ni	M
0.09	1.1	0.1	0.4	

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				+20°C	-40°C	-60°C	
AW	340	470	20	65			

WELDING PARAMETERS PACKING

Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A)	kg / package	kg / pack
3.2	1000		5	25