

SG1

CATEGORY	GMAW-GTAW Solid wires
TYPE	Copper coated welding wire developed for MAG welding of un and -low alloyed steels with low silicon and manganese content.

APPLICATIONS	Shipbuilding, offshore, repair, construction, car-plate welding etc...
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PROPERTIES	Extreme easy to weld with excellent welding properties suitable for welding galvanized plates or weld deposits that have to be galvanized afterwards due to the low silicon content. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas.
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CLASSIFICATION	AWS EN ISO DIN	A 5.18: ER 70S-3 14341-A: G 35 AMZ G2Si 8559: SG1
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SUITABLE FOR	St 33 - St 52 ,A, E, AH, EH ,HI-HIII, 17Mn4, St 37.0/4 - St 52.0/4, StE 255 - StE 420
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APPROVALS	CE approved
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WELDING POSITIONS:	
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WELD METAL ANALYSIS %					
C	Mn	Si	Cr	Ni	Mo
0.07	1.20	0.60			

MECHANICAL PROPERTIES				
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V 20°C
AW	380-460	480-600	24-32	90

AW: as welded

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	Spool type	kg / spool	kg / pallet
0.6	14-22	30-90	D-200 / K-300 / D-300	5 / 15	1005 / 1080
0.8	18-24	60-200	D-200 / K-300 / D-300 / Drum / B3	5 / 15 / 250 / 300	1005 / 1080 / 1000
1.0	18-32	80-300	D-200 / K-300 / D-300 / Drum / B3	5 / 15 / 250 / 300	1005 / 1080 / 1000
1.2	18-35	120-380	D-200 / K-300 / D-300 / Drum / B3	5 / 15 / 250 / 300	1005 / 1080 / 1000
1.6	28-38	225-550	K-300 / D-300 / Drum / B3	5 / 15 / 250 / 300	1080 / 1000

REDRYING TEMPERATURE	not required
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GAS ACC. EN ISO 14175:	M2, M3, C1
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