

SG1 Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Copper coated welding wire developed for Tig welding of un and -low alloyed steels with low silicon and manganese content.

APPLICATIONS Shipbuilding, offshore, repair, construction, car-plate welding etc...

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.

CLASSIFICATION

AWS	A 5.18: ER 70S-3
EN ISO	636-A: W 42 5 W 2 Si
DIN	8559: SG1

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

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo
0.08	1.20	0.57			

MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	R _{p0,2} (MPa)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V		
				0°C	-20°C	-50°C
AW	470	560	30			225

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters		Packing	
D (mm)	Current (A) (DC-)	Single	Master
1,6 x 1000 mm	50-90	5 kg cartons	25 kg cartons
2,0 x 1000 mm	70-110	5 kg cartons	25 kg cartons
2,4 x 1000 mm	110-180	5 kg cartons	25 kg cartons
3,2 x 1000 mm	150-250	5 kg cartons	25 kg cartons
4,0 x 1000 mm	180-320	5 kg cartons	25 kg cartons

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1-3