

SG2 Tig

CATEGORY	GMAW-GTAW Solid wires		
TYPE	Copper coated welding wire for welding un and -low alloyed steels upto 420Nmm2 yield strenght.		
APPLICATIONS	Shipbuilding, piping, bridges, repair, construction, car-plate welding etc...		
PROPERTIES	Extreme easy to weld with excellent welding properties and low fume, extreme subzero impact properties due to the Tig process.		
CLASSIFICATION	AWS	A 5.18: ER 70S-6	
	EN ISO	636-A: W 42 5 W 3 Si 1	
	DIN: W.Nr.	1.5125	
	DIN	8559: SG2	

SUITABLE FOR	Base metal	DIN	EN	ASTM
Shipbuilding	Un alloyed steel	A, B, D, AH 32 till EH 36	~~~~~	A 131 / A 106
Boiler steels	-	St 33, St 37-2, St 52-3	P235GH, P265GH, P295GH	A 515 / A 715
-	Pipe steels	HI, HII, 17Mn4, 19Mn5	-	A 283 / A 285
-	-	20Mn5	-	A 414 / A 662
-	Fine grain steels	St 35.8, St 45.8	P235T1/T2 - P355N	A 372 / A 369
-	API steels	StE 210.7TM - StE 380.7TM	L210 - L380	A 210 / A 516
		StE 255 till StE 420	S255 - S420	A 255 / A 333
		X42	X42	A 350 / A 612

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	P	S
0.08	1.45	0.85	-	-	-	<0.025	<0.025

MECHANICAL PROPERTIES

Gas type	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				+20°C	-40°C	-60°C	
I1	>430	>540	>24	200	150	75	

WELDING PARAMETERS / PACKING

Welding Parameters		Packing	
D (mm)	Current (A) DC-	single	master
1,0 x 1000 mm	40-80	5 kg cartons	25 kg cartons
1,2 x 1000 mm	30-70	5 kg cartons	25 kg cartons
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

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1