

G2

CATEGORY	Oxi-Acetylene welding								
TYPE	Copper-coated unalloyed rod for gas welding								
APPLICATIONS	Gas welding of unalloyed steels with a minimum tensile strength of 400 MPa								
PROPERTIES	Joints are homogenous and soft, the mechanical treatment is very good								
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.2: ~R 60</td> </tr> <tr> <td>EN ISO</td> <td>12536: O2</td> </tr> <tr> <td>DIN: W.Nr.</td> <td>1.0494</td> </tr> <tr> <td>DIN</td> <td>8554: G2</td> </tr> </table>	AWS	A 5.2: ~R 60	EN ISO	12536: O2	DIN: W.Nr.	1.0494	DIN	8554: G2
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EN ISO	12536: O2								
DIN: W.Nr.	1.0494								
DIN	8554: G2								
SUITABLE FOR	S235G2T, S255GT, S235JO, S275JO, P235G1TH, P255G1TH, P235GH, P265GH, P285NH								

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si
0.10	1.0	0.08

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	>300	>400	>20	>47			

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