

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 %

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)	A ₅ (%)	Impact Energy (J) ISO-V 20°C
AW	380-460	480-600	24-32	>150

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
-------------------------------	------