

SG 2

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. High world wide excepted quality with controlled cast en helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas.

CLASSIFICATION

AWS	A 5.18: ER 70S-6
EN ISO	14341-A: G 42 4 M21 3Si 1 14341-A: G 42 3 C 3Si 1
DIN: W.Nr.	1.5125
DIN	8559: SG2

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

APPROVALS TUV (12398.00), DB (42.206.01), CE approved



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	
M21	>430	>540	>24	150	90		
C1	>390	>470	>24	100	70		

WELDING PARAMETERS / PACKING

Welding Parameters		Packing	
D (mm)	Current (A) DC+	spool type	kg / spool / drum
0.6 mm	30-90	D-200 / D-300	5 / 15
0.8 mm	60-200	D-200 / K-300 / drum	5 / 15 / 250
1.0 mm	80-300	D-200 / K-300 / drum	5 / 15 / 250
1.2 mm	120-380	D-200 / K-300 / drum	5 / 15 / 250
1.6 mm	225-550	D-200 / K-300 / drum	5 / 15 / 250

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M21, C1