

## SG 2 Tig

<b>CATEGORY</b>	GMAW-GTAW Solid wires		
<b>TYPE</b>	Copper coated welding wire for welding un and -low alloyed steels upto 420Nmm <sup>2</sup> yield strenght.		
<b>APPLICATIONS</b>	Shipbuilding, piping, bridges, repair, construction, car-plate welding etc...		
<b>PROPERTIES</b>	Extreme easy to weld with excellent welding properties and low fume, extreme subzero impact properties due to the Tig process.		
<b>CLASSIFICATION</b>	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		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** 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	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	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