

MIG/MAG Welding Wire for High Strength and Low Alloyed Steels

Classification

EN ISO 16834 : G Mn3Ni1Cu
 EN 440 : G3 Ni1*
 AWS A5.28 : ER80S-G

(*) Nearest classification

General Description

It is a low c alloyed GMA welding wire, used for the welding pressure vessels and gas pipes including nickel. It gives a weld metal that has an high mechanical properties against atmospheric environment.

Industry: Petro-chemical industry

Chemical Composition (w%), Typical, Wire

C	Si	Mn	Ni	Cu
0.09	0.60	1.40	0.90	< 0.40

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 530 N/mm²
 Tensile Strength : 610 N/mm²
 Elongation (L=5d) : 26 %
 Impact (ISO-V) : 120 J (+20°C)
 60 J (-40°C)

Shielding Gases (ISO 14175 / EN 439)

MIG : M21 - Ar + 5-25% CO₂
 C1 - CO₂ (100%)

Current Type and Polarity : DC (+)

Materials to be Welded

	DIN	EN
Fine Grained Steels	StE 255 - StE 380 TStE 255 - TStE 380	S255N ; S420N S255NL - S380NL ; P275NL1 - P355NL1
Weather Resisting Steels	WTSt 37.2 - - - -	S235JRW S355J2G1W, S235J0W, S235J2W S355J01, S355J2W, S355K2G1W Patinax®-F, Patinax®-37 Cor-Ten®-A, Cor-Ten®-B 9CrNiCuP3-2-4
Low Temperature Steels	TTS135 - -	S225NL 11MnNi5-3 13MnNi6-3

Packing and Diameter Informations

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight
MIG/MAG Wire	X	X	X	-	-	-	-	15 kg