



Solid MAG welding wire

SG-2

Type: Copper coated welding wire developed for MAG welding of un and -low alloyed steels.

Applications: Shipbuilding, offshore, repair, construction, car-plate welding etc...

Unalloyed steels:	St 33 – St 52
Ship building:	A, E, AH, EH
Boiler steels:	HI-HIII, 17Mn4, 19Mn5
Pipe steels:	St 37.0/4 – St 52.0/4
Fine-grain steels:	StE 255 – StE 420

Properties: Extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas.

Norm:

AWS A.5.18 :	ER 70 S-6
DIN 8559 :	SG 2
W.Nr :	1.5125
EN 440 :	G 42 4 M G 3 Si 1

Approvals: Rina, TUV, LR, ABS, BV, DNV, GL, DB, CL, JR, USSR, OBB

Welding positions : according EN 287: PA, PB, PC, PD, PE, PF, PG

Analyses %

0.08	1.45	0.85	< 0.15	< 0.02	-
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Mechanical properties

Shield gas	R _{PO,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact strenght ISO-V-J	
				+20 °C	- 40 °C
C1					
M21	> 450	> 540	> 24	~ 150 J	~ 90 J

- Recommended heat input : 8 – 13 KJ/cm.

Sizes: MAG 0,6 mm, 0,8 mm, 1,0 mm, 1,2 mm, 1,6 mm

Package: D-200, K-300, D-300, Drum, B3

Current DC +