

TIG-LANKA SG2 1,2MM/5KG ER70S-6/G3Si1 ITALFIL



Tuote

Tuotekoodi: ITSG212
Viivakoodi: 9638000000006

Tekniset tiedot

Paino: 1 kg

SG2

UNALLOYED WELDING WIRES

SFA-AWS A5.18 ER70S-6

EN ISO 14341-A- G 42 4 C1/M21 3Si1

EN ISO 636-A- W 42 4 3Si1

Average Chemical analysis

C%	Si%	Mn%	P%	S%	Cu%	Cr%	Ni%	Mo%	Al%	V%	Zr+Ti%
0,070	0,85	1,45	< 0,020	< 0,020	< 0,25	< 0,15	< 0,15	< 0,050	< 0,020	< 0,030	< 0,15

The copper value include the surface coating

Typical mechanical properties of all-weld metal

Rm	Rs	Al	Kv
N/mm²	N/mm²	%5d	-40°C
550	450	> 24	> 80 J

The mechanical properties are approximate and may range on the basis of the Heat, shielding gas, welding parameters and other factors

Welding process

Protection	MIG: EN ISO 14175 C1, M20, M21, M33 and similar / TIG: I1 (Argon)
Current and polarity	MIG: DC+ / TIG: DC-
Welding positions	EN ISO 6947: PA, PB, PC, PD, PE, PF, PG
Post Welding Heat Treatment	as welded

Dimensions

MIG (mm)	0,60 - 0,80 - 0,90 - 1,00 - 1,14 - 1,20 - 1,40 - 1,60
TIG (mm)	1,00 - 1,20 - 1,60 - 2,00 - 2,40 - 3,00 - 3,20 - 4,00

BASE MATERIALS TO BE WELDED

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420

APPLICATIONS

Copper coated solid wire suitable for single pass or multipass welding of non alloy steels. It can be used for boilers fabrication, industrial machinery construction, car production.

APPROVALS

Contact ITALFIL

