

# TIG-LANKA SG2 3,2MM/5KG ER70S-6/G3Si1 ITALFIL



## Tuote

Tuotekoodi:	ITSG232
Viivakoodi:	9642000000003

## Tekniset tiedot

Paino:	1 kg
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## 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
<b>N/mm<sup>2</sup></b>	<b>N/mm<sup>2</sup></b>	<b>%5d</b>	<b>-40°C</b>
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

