



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

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 %

C	Mn	Si	Ti+Zr	Al	Zr
0.08	1.45	0.85	< 0.15	< 0.02	-

Mechanical properties

Shield gas	R _{P0,2} (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 +

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application