MIGWELD 2

MIG/MAG Wires [GMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14341-A : G 42 4 M21 3Si1 / G 38 2 C1 3Si1 DIN 8559 : SG 2 AWS A-5.18 : ER 70 S-6 W.Nr. : 1.5125	UDT, TUV	Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Shipbuilding&Offshore Agriculture Light construction and hobby

- Solid copper coated welding wire for welding mild steels and low alloyed steels.
- Very little spatter.
- During root pass, the melting of the wire is continuous without any interruption.
- The material is characterized by high wettability of the walls.

Application

Steel constructions, machines, pipelines, boiler installations, ship steels, etc.

Base material

	EN
Construction steels:	S235-S355
Boiler plates:	P235GH-P355GH
Pipelines:	P235-P355N
Shipbuilding plates:	A, B, D, E, AH32-EH36
Finegrained steels:	S275-S420
ASTM A139/ A219 Gr A1, C/A36/A 234 Gr WPB/A334 Gr1/ A106 Gr A, B, C,/A 131 Gr A, B, D/ API 5LX42/ API 5LX46/ API 5LX52/ API 5LX60/ API 5LX65	

Typical chemical composition %

C	Si	Mn	P	S
0,08	0,90	1,5	<0,025	<0,025

Typical mechanical properties

Yield strength Re [N/mm2]	>420
Tensile strength Rm [N/mm2]	500-640
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (-40°C) /
Shielding gases acc. to EN ISO 14175	C1 - 100% CO2 / M21 - Ar + 15 - 25% CO2 / M23 - Ar + 5%CO2 + 4%O2 /

Welding parameters and packing

⌀	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	60-180	18-24	15,0
1,0	90-300	19-32	15,0
1,2	130-360	19-35	15,0

1,6	200-400	22-36	15,0

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