

### CLASIFICARE / STANDARDS

AWS A5.18-93:	ER70S-6
EN ISO 14341-A:	G423 C G3Si1
EN ISO 14341-A:	G424 M G3Si1

### AUTORIZARI / APPROVALS

TÜV:	G42 2(M)G 3Si1	GL:	3YS
DB:	42.116.01	RINA:	SG42-52A3
ABS:	3SA-3YSA	BV:	SA3M-SA3YM

### CARACTERISTICI PRINCIPALE

Sarma plina cuprata pentru sudare in mediu de gaz protector in toate pozitiiile. Se utilizeaza ca gaz de protectie Ar/CO<sub>2</sub>, Ar/CO<sub>2</sub>/O<sub>2</sub> sau CO<sub>2</sub>. Indicat pentru sudarea intr-o singura sau mai multe treceri a otelurilor nealiate, cu rezistenta de rupere la tractiune pana la 560 N/mm<sup>2</sup> (tip SG55J2G3 EN 10025 FE 510/St52 sau similar). Arc electric stabil, stropire redusa, aspect estetic al cordonului.

### MAIN FEATURES

Copper coated solid wire for GMAW welding in all position. To be used with Ar/CO<sub>2</sub>, Ar/CO<sub>2</sub>/O<sub>2</sub> or CO<sub>2</sub> shielding gas. Suitable for single pass or multipass welding of non alloy steels, with tensile strength up to 560 N/mm<sup>2</sup>, type SG55J2G3 EN 10025 (FE 510/St 52) and similar. Stable electric arc, good extetical bead, very low spatters.

### DOMENII DE APLICATIE

Constructii navale, boilere (inclusiv cele din industria petrochimica);  
Industria constructoare de masini;  
Constructii metalice;  
Fabricarea tevilor;  
Constructia autovehiculelor si aplicatii electrocasnice;  
Constructii feroviare.

### MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry);  
Industrial machinery construction;  
Metal working industry;  
Pipes fabrication;  
Car, bus production and electro-domestic appliances;  
Coachbuilders.

### POZITII DE SUDARE / WELDING POSITIONS



1G	2F	2G	3G	3G	4G	5G	5G	AWS
PA	PB	PC	PF	PG	PE	PF	PG	EN

### CURRENT / CURRENT: DC+

GAZ / GAS: Ar / CO<sub>2</sub> - Ar / CO<sub>2</sub> / O<sub>2</sub> - CO<sub>2</sub>  
M2, M3, C1 (EN 439)

### ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cu				
0.06 - 0.13	1.3 - 1.6	0.70 - 1.00	≤ 0.025	≤ 0.025	0.25				

### CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm <sup>2</sup>	Rs N/mm <sup>2</sup>	E % 5d	Kv J -30°C	Kv J -40°C
Ar/CO <sub>2</sub> (M21)	Stare sudată/As welded	510 - 560	≥ 430	≥ 24	≥ 70	≥ 47
CO <sub>2</sub>	Stare sudată/As welded	510 - 560	≥ 430	≥ 24	≥ 47	

### AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm					
		0.6	0.8	1.0	1.2	1.6	
B 300	16 kg	W000282634	W000282640	W000282651	W000282660	W000282669	
B 300/SS	16 kg		W000282641	W000282652	W000282661	W000282670	
S 300	15 kg		W000282638	W000282649	W000282658	W000282667	
S 300/SS	15 kg		W000282639	W000282650	W000282659	W000282668	
S 200	5 kg	W000282632	W000282636	W000282647			
SQPA	250 kg		W000282645	W000282656	W000282665		
Drum	200 kg					W000282673	
Drum	400 kg		W000282644	W000282655	W000282664		

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.