

# CERTIFICATE OF QUALITY

## SG2

**CATEGORY:** GMAW-GTAW Solid wires.

**TYPE:** Copper coated welding wire for welding un and -low alloyed steels upto 420Nmm<sup>2</sup> yield strenght.

**APPLICATIONS:** Shipbuilding, piping, bridges, repair, construction, car-plate welding etc...

**PROPERTIES:** Extreme easy to weld with excellent welding properties. High world wide excepted quality with controlled cast en helix for semi and or semi-automatic applications. Weldable with Co<sub>2</sub> and Mix gas.

**CLASSIFICATION:**

AWS A 5.18: ER 70S-6

EN ISO 14341-A: G 42 4 M21 3Si 1 / 14341-A: G 42 3 C 3Si 1

DIN: W.Nr. 1.5125 | DIN 8559: SG2

**SUITABLE FOR:**

Base metal	DIN	EN	ASTM
Shipbuilding Un alloyed steel	A, B, D, AH 32 till EH 36 St 33, St 37-2, St 52-3	P235GH, P265GH, P295GH	A 131 / A 106 A 515 / A 715
Boiler steels	HI, HII, 17Mn4, 19Mn5	-	A 283 / A 285
-	20Mn5	P235T1/T2 - P355N	A 414 / A 662
Pipe steels	St 35.8, St 45.8	L210 - L380	A 372 / A 369
-	StE 210.7TM - StE 380.7TM	S255 - S420	A 210 / A 516
Fine grain steels	StE 255 till StE 420	X42	A 255 / A 333
API steels	X42		A 350 / A 612

**WELDING POSITIONS:**



**TYPICAL WELD DEPOSIT WEIGHT:**

Dia (mm)	Chemical Composition (%)								
	C	Si	Mn	P	S	Cr	Ni	Cu	Mo
1.0MM	0.080	0.85	1.45	0.013	0.012	0.020	0.010	0.150	0.0025
<b>Melting metal mechanical performance</b>									

	RP0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 %	Impact Energy (J) ISO-V +20°C    -40°C		Hardness HRc / HV
	>430	>540	>24	150	90	

**WELDING PARAMETERS / PACKING:**

Welding Parameters		Packing	
D (mm)	Current (A) DC+	spool type	kg / spool / drum
0.8	60~200	D270/ Drum	15 / 250
1.0	80~300	D270/Drum	20 / 250
1.2	120~380	D270/ Drum	20 / 250
1.6	220-550	D270/ Drum	20 / 250

Quality Control Stamp:

Date: March-17,2019

