MAG SOLID WIRE

STEEL (G3SI1)

NON-ALLOY STEELS

INVEST IN THE FUTURE

This solid, copper-coated wire is for gas welding non- and low-alloy carbonated steel. It has many useful applications in metal construction due to its excellent mechanical properties.

Classification

AWS 5.18 : ER 70S-6
EN ISO 14341-A : G46 4 M21 3Si1 / G 42 3 C1 3Si1
DIN 8559 : SG2

Applications

- Automotive production
- Railway construction
- Shipbuilding
- Construction
- Tanks and boilers

S100

S200
S270
S300

B300

Benefits

- Excellent ignition properties
- Great arc stability on high currents
- A good, corrosion-resistant wire
- Enables welding in all positions

Polarity

DC +

Chemical properties

C %	Mn %	Si %	S %	P %	Cu %
0.07	1.40	0.80	0.012	0.012	0.10

Mechanical properties

Re	Rm	A 5 d	KV 20°C	KV -20°C	KV -40°C
470 Mpa	560 Mpa	26%	150 J	90 J	50 J

Recommendations

Wire Ø (mm)	0.8	1.0	1.2
thickness (mm)	< 5	6 ▶ 8	8 ▶ 12
voltage (V)	16 ▶ 28	17 ▶ 32	18 ▶ 34
current (A)	60 ▶ 200	80 ▶ 260	100 ▶ 360

Gas protection in compliance with EN ISO 14175
100% CO2 (C1) or Argon / CO2 (M21, 8 < 20% CO2)

Packaging

Wire reel type			Wire diameter (mm)			
weight (kg)			Ø 0.6	Ø 0.8	Ø 1.0	Ø 1.2
0.9	S100	—	086593	086609	—	—
5	S200	—	086111	086128	086135	—
15	S270	—	—	086227	086234	086241
	S300	—	086166	—	—	—
18	—	B300	—	086272	086289	086296

CE

MADE in China

www.gys.fr