

SG 2

mild Steel MAG-Wire TIG-Rod

Specifications:

Werkstoff Nr.	1.5125
MSG: EN 440	G3Si1
WIG: EN 1668	W3Si1
AWS-Bezeichnung:	ER 70S-6

Application:

Wire for welding mild and low-alloy steels.
MAG wire for welding in all positions with CO₂ or mixed shielding gas.

Chemical Composition C: 0,10 Si: 0,85 Mn: 1,45
Element by weight (%):

Mechanical Properties:

typical)

Yield Point(Re)	370 - 470 N/mm ²
Tensile Strength (Rm)	470 - 570 N/mm ²
Elongation (A)(Lo=5do)	~ 25%
Impact energy (Av)	130 - 100 J
High temp.	450°C (TIG)
Low temp.	-40°C (TIG)

Approvals :

TÜV, DB, CE-Zeichen

Shielding Atmosphere:

TIG-rod	I 1
MAG-wire	M 2, C

Typical Base Mat.:

St 35 - St 55, St 35.4 - St 55.4
StE255 - StE 380
H1 - H11, 17Mn 4, 19Mn6
GS 38 - GS 52
S235JRG2 – S355J2 P235GH P265GH P295GH
Feinkorn bis S420N
TÜV-Kennblatt 1000: Gruppe 1-4
ISO 20172: Gruppe 1.1 / 1.2 / 1.3 (ReH max 420N/mm²)
ISO 20172: Gruppe 2.1 (ReH max 420N/mm²)
ISO 20172: Gruppe 3.1 (ReH max 420N/mm²)

Packaging:

MIG/MAG: spools D 100 / D 200 / K 200 / K 300
TIG: 25-kg-boxes
the rods are marked with DT-SG2