

❖ Product Description

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|---|---|
| I. Premium quality solid wire for mild steels | IV. The weld bead formation is excellent |
| II. Uniform copper coating for smooth feedability | V. Minimum spatter occurrence when under optimum conditions |
| III. The Magnesium content is kept higher to increase the strength of the weldmetal | |

❖ Range of Application

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|---|--------------------------------------|
| I. Good for welding of steel structure | III. Welding in pipeline application |
| II. Finds application in welding of heavy machineries | IV. For robotic welding |
| | V. Welding in heavy containers |

❖ Classification:

- EN ISO 14341 G4 Si1

❖ Chemical Composition

Type of Wire		C	Mn	S	Si	P	Al	Ti+Zr	Cr	Mo	V	Cu
G4 Si1	Min	0.06	1.60	-	0.80	-	-	-	-	-	-	-
	Max	0.14	1.90	0.025	1.20	0.025	0.02	0.15	0.15	0.15	0.03	0.35

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -40°C
As Welded	530-680	460	20	47J

❖ Wire Size & Weld Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- All position

❖ Current and Gas- Flow Rate

- DCEP & 15-22 lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Note: -

All the value above mentioned are typical values.

- (1) All the value above mentioned are typical values
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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