

DT-SG 2

mild Steel MAG-Wire TIG-Rod

Specifications

MSG: EN ISO 14341 :G 42 4 M G3Si1
 WIG: EN ISO 636-A W 38 4 W3Si1
 AWS/ASME-SFA5.18: ER 70S-6
 (Werkstoff Nr. 1.5125)

Application

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

Chemical Composition Element by weight (%)

C: 0,10 Si: 0,85 Mn: 1,45

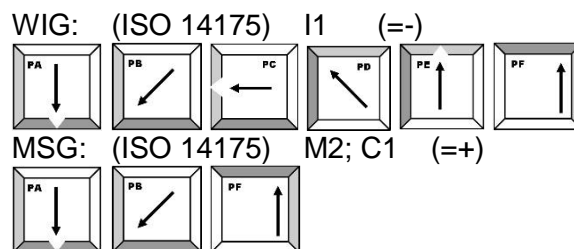
Mechanical Properties typical)

Yield Point(Re) 370-470 N/mm²
 Tensile Strength (Rm) 470-570 N/mm²
 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 gas/Polarity



Typical Base Material

St 35 - St 55, St 35.4 - St 55.4
 StE255 - StE 380
 HI - HII, 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