

## TECHNICAL DATA SHEET NOVOFIL (SG2) WELDING WIRES

Classification of the material according to the international spec.

AWS A5.18: ER70S-6  
 DIN 8559: SG2  
 ISO 14341-A G 42 4 M G3 SI 1

Welding wire to be used under protective gases Co<sub>2</sub> for general applications. The wire can be copper coated, bronze coated, uncoopered.

The wire is spooled on plastic or basket reels from 1 kg up to 25 kgs and drums from 75 up to 500 Kgs.

### *Materials*

St. 37 – St 52, H I – III, 17 Mn 4, steel St 35 , St. 35.8, St. 45.8, SIE 420.

### *Typical chemical details ( %)*

<i>C</i>	<i>Mn</i>	<i>Si</i>
0.07-0.08	1.45-1.50	0.85

### *Mechanical properties of welded material as per DIN 32 525 ( min.)*

*Welding wire to be used under Protective gas Co<sub>2</sub> / M21 mix gas for general applications*

<b>Tensile Strenght :</b> (N/mm <sup>2</sup> )	> = 530	CO <sub>2</sub> /M21
<b>Yeld strenght:</b> (N/mm)	> = 420	CO <sub>2</sub> /M21
<b>Elongation:</b> (A 5 %)	24 – 29	CO <sub>2</sub> /M21

### *Amperage & Power*

<i>Dia. (mm).</i>	<i>0,80</i>	<i>1,00</i>	<i>1,20</i>	<i>1,60</i>
Amperage	70 - 210	90 – 310	130 – 350	220 – 410
Volts	18 - 23	18 – 28	18 – 30	24 – 34
Power	CC-EP	CC-EP	CC-EP	CC-EP