

CLASSIFICATION

EN ISO 14341-A	AWS / ASME SFA-5.28	W. Nr.
G 42 2 C/M 2Ti	ER70S-2	1.5125

DESCRIPTION AND APPLICATION

A copper or bronze coated solid wire alloyed with titanium for welding of carbon and carbon-manganese steels with tensile strength up to 510 N/mm². Due to it's titanium addition it is suitable for single-pass welding of galvanized, primer coated or oxidized steels.

Steel grade	HRN	DIN (W. Nr.)		HRN / EN / ISO	
Constructional steels	Č 0261 to Č 0545	St 33 (1.0035) to St 52-2N (1.0050)		S 185 do E 295 Fe 310-0 do Fe 490-2	
Boiler steels	Č 1202 Č 1204	HI (1.0345)	HI1 (1.0425)	P235GH	P265GH
	Č 3133 Č 3105	17Mn4 (1.0481)	19Mn6 (1.0473)	P295GH	P355GH
Tube and pipe steels	Č 1212 to Č 3100	St 35.8 (1.0305) to St 45.8 (1.5415)		DX55D do P355T2	

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R _{eL} N/mm ²	R _m N/mm ²	A ₅ %	KV (-20°C) J
> 430	540 - 640	> 20	≥ 47

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Si	Mn	Ti
%	0,04 - 0,06	0,5 - 0,8	1,1 - 1,5	0,1 - 0,12

SHIELDING GAS

C1 ili M21

PACKAGING

Wire diameter mm	Winding
0,8; 1,0; 1,2	precision-wound (S-S)
15 kg - metal spool (S-S)	

APPROVALS

DB; TÜV

