

MIG G3Si1

MIG/MAG Wires [GMAW]

Construction, unalloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14341-A : G 42 4 M21 3Si1/G 42 2 C1 3Si1		Power generation industry Constructions & Engineering Metallurgy (Steelworks) Mining Petrochemical and chemical industry Shipbuilding&Offshore Agriculture Light construction and hobby

Drut spawalniczy manganowo-krzemowy, pomiedziowany, do zastosowania przy spawaniu metodą MIG/MAG stali niskowęglowych i niskowęglowych.

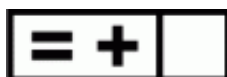
Typical chemical composition %

C	Si	Mn	P	S
0,08	0,90	1,50	<0,025	<0,025

Typical mechanical properties

Yield strength Re [N/mm²]	>460
Tensile strength Rm [N/mm²]	>560
Elongation A5 [%]	>30
Impact energy Kv [J]	>47J (-40°C) /

Welding current



Welding positions



Shielding gases acc. to EN ISO 14175

C1 - 100% CO₂ / M21 - Ar + 15 - 25% CO₂ /

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	60-185	18-24	15,0
1,0	80-300	18-32	15,0
1,2	120-380	18-35	15,0

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