

XP SG2 CF (COPPER FREE)

MILD STEEL



CLASSIFICATIONS

| EN ISO 14341-A | AWS A5.18 |
|----------------------------------|-----------|
| G 42 3 C1 3Si1 / G 42 4 M21 3Si1 | ER70S-6 |

KEY FEATURES AND APPLICATIONS

- Solid non-copper-coated wire for welding unalloyed and low-alloyed carbon-manganese steels.
- Provides a minimum yield strength of 420 MPa.
- Offers minimal spatter and can be used with both C1 and M21 shielding gases.
- Excellent mechanical properties at subfreezing temperatures down to -40°C.
- Ideal for a variety of applications, including structural steel, piping, automotive components and general metalworking.

BASE MATERIALS

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML

CHEMICAL COMPOSITION OF WIRE %

| | C | Si | Mn | P | S | Ni | Cr | Mo | V | Cu | Al | Ti + Zr |
|-----|------|------|------|-------|-------|------|------|------|------|------|------|---------|
| MIN | 0.06 | 0.70 | 1.30 | - | - | - | - | - | - | - | - | - |
| MAX | 0.14 | 1.00 | 1.60 | 0.025 | 0.025 | 0.15 | 0.15 | 0.15 | 0.03 | 0.35 | 0.02 | 0.15 |

Single values are maximum values according to EN ISO 14341

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES - M21

| Yield Strength (MPa) | Tensile Strength (MPa) | Elongation (%) | Impact ISO-V (J) | Test Temperature |
|----------------------|------------------------|----------------|------------------|------------------|
| 480 (≥420) | 570 (500 - 640) | 28 (≥20) | 100 (≥47) | -40°C |

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

| Shielding Gases | Polarity |
|------------------------|----------|
| EN ISO 14175 - C1, M21 | DC+ |

PACKAGING AND AVAILABLE SIZES

| Part Number | Diameter (mm) | Spool | Weight (kg) | Pallet Qty |
|-------------|---------------|-------|-------------|------------|
| XP12205 | 0.8 | BS300 | 15 | 72 |
| XP12210 | 1.0 | BS300 | 15 | 72 |
| XP12215 | 1.2 | BS300 | 15 | 72 |

250kg drums also available from stock