

## XP SG2 (G3Si1)

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 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
XP10244	0.6	BS300	15	72
XP10245	0.8	BS300	15	72
XP10246	1.0	BS300	15	72
XP10247	1.2	BS300	15	72
XP10248	1.6	BS300	15	72

1kg, 5kg and 250kg drums also available from stock