



# Weld G3Si1

A copper coated, G3Si1 solid wire for GMAW of all general structural and engineering unalloyed and low-alloyed carbon-manganese steels. The electrode may be welded with either a gas mixture or with pure CO<sub>2</sub> as the shielding gas.

## Dane techniczne

|              |                                                                                                                           |
|--------------|---------------------------------------------------------------------------------------------------------------------------|
| Klasyfikacje | EN ISO 14341-A : G 38 2 C1 3Si1<br>EN ISO 14341-A : G 42 3 M21 3Si1<br>EN ISO 14341-A : G 3Si1<br>SFA/AWS A5.18 : ER70S-6 |
| Aprobaty     | CE : EN 13479<br>DB : 42.039.39<br>NAKS/HAKC : 1.2MM<br>VdTÜV : 13038                                                     |

Zatwierdzenia s oparte na lokalizacji fabryki. Aby uzyska więcej informacji, skontaktuj si z ESAB.

|              |                                        |
|--------------|----------------------------------------|
| Rodzaj stopu | Carbon-manganese steel (Mn/Si-alloyed) |
|--------------|----------------------------------------|

### Typowe waciwoci mechaniczne

| Warunki                         | Granica plastycznoci | Wytrzymaao na rozciąganie | Wyduenie wzglдне |
|---------------------------------|----------------------|---------------------------|------------------|
| EN 80Ar/20CO <sub>2</sub> (M21) |                      |                           |                  |
| Po spawaniu                     | 470 MPa ( 68 ksi )   | 560 MPa ( 81 ksi )        | 26 %             |

### Udarno Charpy V

| Warunki                         | Temperatura testu | Udarno KV         |
|---------------------------------|-------------------|-------------------|
| EN 80Ar/20CO <sub>2</sub> (M21) |                   |                   |
| Po spawaniu                     | -30 °C ( -22 °F ) | 70 J ( 52 ft-lb ) |

| Skad drutu % |      |      |
|--------------|------|------|
| C            | Mn   | Si   |
| 0.078        | 1.46 | 0.85 |

| Dane wydajności stopiwa |           |         |                                       |                                   |
|-------------------------|-----------|---------|---------------------------------------|-----------------------------------|
| rednica                 | A         | V       | Prdko podawania drutu                 | Wydajno stopiwa                   |
| 0.8 mm<br>( 0.030 in. ) | 60-180 A  | 18-22 V | 3.2-11.0 m/min<br>( 126-433 in./min ) | 0.8-2.6 kg/h<br>( 1.8-5.7 lbs/h ) |
| 1.0 mm<br>( 0.040 in. ) | 80-250 A  | 18-30 V | 2.7-13.0 m/min<br>( 106-512 in./min ) | 1.0-4.8 kg/h<br>( 2.2-10. lbs/h ) |
| 1.2 mm<br>( 0.047 in. ) | 120-330 A | 18-34 V | 2.3-13.0 m/min<br>( 91-512 in./min )  | 1.3-6.9 kg/h<br>( 2.9-15. lbs/h ) |

| Parametry spawania  |  |
|---------------------|--|
| rednica drutu       |  |
| 1.6 mm ( 1/16 in. ) |  |