

**Standards**

TS EN ISO 21952-A	: G MoSi
EN ISO 21952-A	: G MoSi
TS EN ISO 21952-A	: W MoSi
EN ISO 21952-A	: W MoSi
AWS A5.28	: ER 80 S-G (mod.) (ER 70 S-A1)

**Chemical Composition of Welding Wire % (Typical)**

C	Si	Mo	Mn
0.10	0.6	0.5	1.1

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-20°C)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))
min. 460	550 - 670	min. 47 J	min. 22

**Typical Base Material Grades**

- S355J2G3, L320-L415NB, L320MB-L415MB, P255G1TH, P235GH-P355GH, P255NH, 16Mo3, 17MnMoV6-4, 20MnMoNi5-5, 20MnMoNi4-5, GE240-GE300, 22Mo4, S255N-S460N, P255NH-P460 NH

**Features and Applications**

- Copper coated wire for GMAW and rod TIG welding in boiler pressure vessel, pipework and crane construction as well as in structural steel engineering
- High quality, very tough deposit of high crack resistance and non-aging
- Recommended for service in temperature range (-40°C) for TIG, or (-20°C) for GMAW to (+550°C)
- Good copper bonding with low total copper content. Very good welding and flow characteristics
- Preheating interpass and postweld heat treatment as required by base metal
- Shielding gases: MAG; Ar+CO<sub>2</sub>, mix gases, TIG; %100 Ar

**Welding Positions**

**Current Type**

TIG D.C.(-) / MAG D.C.(+)

**Operating Data**

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
<b>BS 300</b>	<b>D 300</b>				BS/D 300
3010201530	3010201557	0.8	0.030"	15	D 200
3010201532	3010201559	1.0	0.040"	15	D 100
3010201534	3010201561	1.2	0.047"	15	ECO PACK
3010201535	3010201563	1.6	0.062"	15	BIG PACK
		(0,6,0,9, 1,14,1,4)		(1,5,15,18,50,250,400)	
	3010300421	1,60 x 1000	1/16 x 39"	5	Carton Box
	3010300422	2,00 x 1000	5/64 x 69"	5	
	3010300423	2,40 x 1000	3/32 x 39"	5	
	3010300424	3,20 x 1000	1/8 x 39"	5	
	3010300425	4,00 x 1000	5/32 x 39"	5	

**Approvals:** SGMo: CE, SEPRO