

Standards

TS EN ISO 14341-A	: G504 M121 Z (3Ni1)
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AWS A5.28	: ER80S-G

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

C	Si	Mn	Ni	Cu	Cr
0.08	0.80	1.30	0.80	0.40	0.20

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength		Elongation ((L ₀ =5d ₀) (%))
		(ISO-V/-20°C)	(ISO-V/-40°C)	
510	590	110 J	60 J	25

Typical Base Material Grades

- S235JRW, S235J2G3, Patinax 37, Alcodur 50, Korlpin 52, S355J2G3Cu, 9CrNiCuP3-2-4, Corten A-B1, Itacor, WTSt37, WTST52.3, S355K2W

Features and Applications

- Excellent resistance to atmospheric events due to the presence of Cu, Cr, Ni
- Suitable for bridges, cranes, ground moving machines, boilers, building structures, petrochemical sector, fans gas pipes, fume section, etc
- Shielding gas: Ar+CO₂ mix gases can be used
- Depending on the thickness of the main material to be used, a pre-heating application can be applied to the main material before starting the welding.

Welding Positions

Current Type

MAG D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6031100122	1.20	0.047"	15	BS 300 Spool

Approvals: CE, SEPRO