



MIG F55

Old reference: MIG GALVARC

Classification

AWS A5.18 : ER70S-2

ISO 14341-A : G2Ti

Description & Applications

Copper coated solid wire for GMAW to weld low alloyed standard construction / boiler steels.

Main applications: Especially for galvanized and Zinc coated steels used for general metal constructions, in the automobile industry, blacksmithing etc.

Typical Chemical Composition (%)

C	Si	Mn	Al	Ti	Cu	Zr	S	P	Fe
0.06	0.6	1.2	0.1	0.1	0.2	0.08	0.01	0.015	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
460	560	28	-20°C 120

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.6	40-90	18-21	EN 439: M21 (Ar/CO ₂) C1 (100% CO ₂) 12-15 l/min
	0.8	60-100	18-21	
	1.0	75-140	18-21	
	1.2	150-220	26-28	
	1.6	180-250	26-32	

Ind.10



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