



SAQ
SIAT

**TECHNICAL SPECIFICATION
GMAW WELDING WIRE
PITTARC GH2**

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1. DESCRIPTION

Gas shielded copper coated welding wire conforming to standard UNI EN ISO 14341-A- G 46 2 M21 Z and AWS A5.28 ER80S-G suitable to join resistant to atmospheric corrosion steels type CORTEN. Available in copper coated wire and *no-copper* wire.

2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al
PITTARC GH2	Min	0.06	1.30	0.70	-	-	0.25	0.70	-	0.30	-
	Max	0.10	1.60	1.00	0.020	0.020	0.40	0.85	0.10	0.50	0.02

Note: Cu heat analysis 0.25÷0.40%

3. WIRE DIMENSIONS

Standard diameter (mm) : 0.8 ; 1.0 ; 1.2 ; 1.4 ; 1.6

Permissible deviations : ISO 544

4. CAST AND HELIX (STANDARD PACKAGING)

Cast (mm) : 800 ÷ 1000

Helix (mm) : maximum 10

5. ALL-WELD-METAL MECHANICAL PROPERTIES

	Re MPa	Rm MPa	A5 %	Z%	KV (-20°C) J
AWS A5.28 ER80S-G	-	≥ 550	-	-	-
EN ISO 14341-A- G 46 2 M21 Z	≥ 460	≥ 530	≥ 20	-	≥ 47
PITTARC GH2	≥ 460	≥ 550	≥ 20	≥ 55	≥ 47

Gas protection: ISO 14175 M21 mixture (80% Ar + 20% CO).

Classification : EN ISO 14341-A- G 46 2 M21 Z

Recommended welding parameters (diam. 1,2 mm): 250÷300A; 25÷30V; wire feed speed ~5m/min; travel speed ~6mm/sec; tip to work ~20mm.

6. STANDARD PACKAGING.

Wire basket rim RG (ISO 544 B300) of 18 kg net weight. Each spool sealed in a polyethylene airtight bag and packed into a cardboard box. 72 spools stacked onto a pallet secured by thermoplastic shrink-wrapping (94x125x80 cm, 1296kg net weight). Available cardboard drums of about 250kg net weight, each one stacked onto a pallet 105x105x90 cm of about 1000kg total weight, secured by thermoplastic shrink-wrapping. On request packaging available from 15 kg up to 700 kg.

7. STANDARD IDENTIFICATION.

A label is attached to the inside of each spool containing nominal diameter, trade name, classification, heat number, operator code. A label is attached to every box containing manufacturer, trade name, nominal diameter, heat number, spool type, references to the standards, CE mark and approvals.



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 PITTARC	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY								
 0036 06 ref. DoP PITTARC GH2-2014-04 EN 13479:2004 Use in metallic structures or in composite metal and concrete structures	PITTARC GH2 Welding wire for carbon steels and fine-grained steels EN ISO 14341-A – G 46 2 M21 Z and AWS A5.28 ER80S-G Shielding gas according to ISO 14175 M21 Current/Polarity G+, Welding positions: <table><tr><td>Weight kg</td><td>Heat N°</td><td>Diameter</td><td>Spool type</td></tr><tr><td>XX</td><td>XXXXX/XX</td><td>X.X mm</td><td>X XXX</td></tr></table>	Weight kg	Heat N°	Diameter	Spool type	XX	XXXXX/XX	X.X mm	X XXX
Weight kg	Heat N°	Diameter	Spool type						
XX	XXXXX/XX	X.X mm	X XXX						

8. STANDARD CERTIFICATION.

Documents according to EN 10204

9. APPROVALS

NONE

