



SAQ
SIAT

**TECHNICAL SPECIFICATION
GMAW WELDING WIRE
PITTARC GTA**

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1. DESCRIPTION

Gas shielded welding wire conforming to the standard UNI EN ISO 16834-A- G 69 4 M21 Mn3Ni1CrMo and AWS A5.28 ER110S-G suitable to join high strength and Cr-Ni-Mo low alloy steels. Available in copper coated wire and *no-copper* wire.

2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	V	Ti
PITTARC GTA	Min	0.08	1.60	0.50	-	-	0.30	1.40	0.24	-	-	0.08	-
	Max	0.11	1.80	0.70	0.015	0.018	0.40	1.60	0.30	0.35	0.12	0.13	0.10
EN ISO 16834-A- Mn3Ni1CrMo	Min	-	1.30	0.40	-	-	0.20	1.20	0.20	-	-	0.05	-
	Max	0.12	1.80	0.70	0.015	0.018	0.40	1.60	0.30	0.35	0.12	0.13	0.10

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 %	KV (-40°C) J
AWS A5.28 ER110S-G	(≥ 660)	≥ 760	(≥ 15)	-
EN ISO 16834-A- G 69 4 M21 Mn3Ni1CrMo	≥ 690	770 ÷ 940	≥ 17	≥ 47
PITTARC GTA	≥ 690	≥ 770	≥ 17	≥ 47

Gas protection : ISO 14175 M21 mixture . Preheating and interpass temperature: 120 ÷ 180 °C

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 GTA-2014-04 EN 13479:2004 Use in metallic structures or in composite metal and concrete structures	PITTARC GTA Welding wire for high strength steels EN ISO 16834-A – G 69 4 M21 Mn3Ni1CrMo and AWS A5.28 ER110S-G Shielding gas according to ISO 14175 M21 Current/Polarity G+, Welding positions: PA, PB, PC, PF APPROVALS : TUV Nr.10886 <table><tr><td>Weight kg</td><td>Heat N°</td><td>Diameter</td><td>Spool type</td></tr><tr><td>XX</td><td>XXXXXX/XX</td><td>X.X mm</td><td>X XXX</td></tr></table>	Weight kg	Heat N°	Diameter	Spool type	XX	XXXXXX/XX	X.X mm	X XXX
Weight kg	Heat N°	Diameter	Spool type						
XX	XXXXXX/XX	X.X mm	X XXX						

8. STANDARD CERTIFICATION.

Documents according to EN 10204

9. APPROVALS

TÜV

