

## 1. DESCRIPTION

Gas shielded welding wire conforming to standard ISO 14341 A G 2Mo and AWS A5.28 ER70S-A1 suitable to join common steels and Mo low alloy steel for construction, pressure vessels and pipes. Particularly suitable to join steels resistant to hot creep up to 500°C and for tack weld in pipe production. Available in copper coated wire, standard and "Innov-Arc", and in no-copper wire, "Green-Arc".

## 2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	V	Ti + Zr
<b>PITTARC GMo</b>	Min	0.08	0.90	0.30	-	-	-	-	0.40	-	-	-	-
	Max	0.12	1.30	0.70	0.020	0.020	0.15	0.15	0.60	0.35	0,02	0.03	0.15
<b>ISO 14341-A G 2Mo</b>	Min	0.08	0.90	0.30	-	-	-	-	0.40	-	-	-	-
	Max	0.12	1.30	0.70	0.020	0.020	0.15	0.15	0.60	0.35	0,02	0.03	0.15
<b>AWS A5.28 ER70S-A1</b>	Min	-	-	0.30	-	-	-	-	0.40	-	-	-	-
	Max	0.12	1.30	0.70	0.025	0.025	-	0.20	0.65	0.35	-	-	-

## 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
<b>AWS A5.28 ER70S-A1</b>	≥ 400	≥ 515	≥ 19	-
<b>ISO 14341-A-G46 4 M21 2Mo</b>	≥ 460	≥ 530	≥ 20	≥ 47
<b>ISO 14341-A-G50 4 M21 2Mo</b>	≥ 500	≥ 560	≥ 18	≥ 47
<b>PITTARC GMo</b>	≥ 400	≥ 515	≥ 19	≥ 47

**Gas protection:** ISO 14175 M21 mixture (80% Ar + 20% CO<sub>2</sub>). Preheating and interpass: < 200 °C.

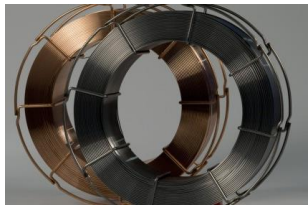
**Classification:** ISO 14341-A- G 46 4 M21 2Mo, ISO 14341-A- G 50 4 M21 2Mo

## 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

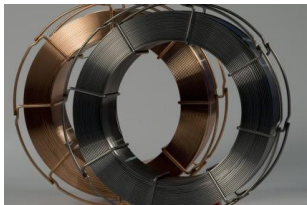
A label is attached to the inside of each spool containing nominal diameter, trade name, classification, heat number, operator code. A label is attached to every box containing manufacturer, trade name, nominal diameter, heat number, spool type,



**SGQ  
SIAT S.p.A.**

references to the standards, CE mark and approvals.

 <b>PITTARC</b>	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY		
  0036 06 ref. DoP PITTARC GMo-2020-10 EN 13479:2017  Use in metallic structures or in composite metal and concrete structures	<b>PITTARC GMo</b>		
	Welding wire for carbon steels and fine-grained steels EN ISO 14341-A – G46/50 4 M21 2Mo and AWS A5.28 ER70S-A1  Shielding gas according to ISO 14175 M21 Current/Polarity G + , Welding positions: PA-PB-PC-PD-PE-PF-PG		
	Weight kg	Heat N°	Diameter
	XX	XXXXX/XX	X,X mm
			Spool type
			X XXX



## 8. STANDARD CERTIFICATION

Documents according to EN 10204.

## 9. APPROVALS

None.