

1. DESCRIPTION

Gas shielded welding wire conforming to the standard UNI EN ISO 16834-A-G Mn3Ni1CrMo and AWS A5.28 ER110S-G suitable to join high strength and Cr-Ni-Mo low alloy steels. 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
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

Zr ≤ 0,10%, Total other elements max 0,25%

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 (-50°C) J
AWS A5.28 ER110S-G	(≥ 660)	≥ 760	(≥ 15)	-
EN ISO 16834-A-G 69 5 M20/M21	≥ 690	770 ÷ 940	≥ 17	≥ 47
PITTARC GTA	≥ 690	≥ 770	≥ 17	≥ 47

Gas protection : ISO 14175 M21& M20 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.

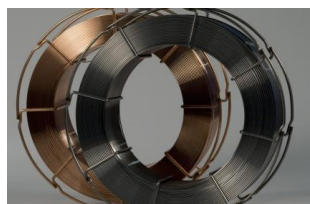
6. STANDARD PACKAGING

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.

SGQ
SIAT S.p.A.



 PITTARC	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY								
 0036 06 ref. DoP PITTARC GTA-2023-01 EN 13479:2017 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 5 M20/M21 Mn3Ni1CrMo and AWS A5.28 ER110S-G Shielding gas according to ISO 14175 M21 & M20 Current/Polarity G + , Welding positions: PA, PB, PC, PF APPROVALS: TUV Nr.10886, DB Nr. 42.044.04 <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

TÜV.