



SAQ
SIAT

**TECHNICAL SPECIFICATION
GMAW WELDING WIRE
PITTARC G6Ni1Ti**

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1. DESCRIPTION

Gas shielded welding wire conforming to the standard UNI EN ISO 14341-A Z and AWS A5.28 EG suitable to join Ni low alloy steels for low temperature applications. 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 G6Ni1Ti	Min	0.05	1.40	0.55	-	-	-	0.80	-	-	-	-	0.040
	Max	0.08	1.60	0.75	0.020	0.020	0.15	1.00	0.15	0.20	0.02	0.03	0.070

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 \pm 1000
Helix (mm) : maximum 10

5. 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.

6. 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, and approvals.

	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY		
PITTARC G6Ni1Ti			
Welding wire for carbon steels and fine grained steels EN ISO 14341-A Z and AWS A5.28 EG			
Shielding gas according to ISO 14175 M21 Current/Polarity G+, Welding positions: PA, PB, PC, PF			
Weight kg	Heat N°	Diameter	Spool type
XX	XXXXX/XX	X,X mm	X XXX

7. STANDARD CERTIFICATION.

Documents according to EN 10204

8. APPROVALS

None

