



SAQ
SIAT

TECHNICAL SPECIFICATION
GMAW WELDING WIRE
PITTARC G6

Document SPP108
Revision 12 i
Date 18.09.2014
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1. DESCRIPTION

Gas shielded welding wire in according to standard UNI EN ISO 14341-A-G 3Si1 and AWS A5.18 ER70S-6 suitable to join common steels for construction, pressure vessels, machinery, ship buildings. Available in copper coated wire and no-copper wire.

2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu *	Al	V
PITTARC G6	min	0.06	1.40	0.80	-	-	-	-	-	-	-	-
	max	0.14	1.60	1.00	0.025	0.025	0.15	0.15	0.15	0.30	0.02	0.03
EN ISO 14341-A-G 3Si1	min	0.06	1.30	0.70	-	-	-	-	-	-	-	-
	max	0.14	1.60	1.00	0.025	0.025	0.15	0.15	0.15	0.35	0.02	0.03
AWS A5.18 ER70S-6	min	0.06	1.40	0.80	-	-	-	-	-	-	-	-
	max	0.15	1.85	1.15	0.025	0.035	0.15	0.15	0.15	0.50	-	0.03

NOTE: * Cu max 0.10% for no-copper wire and wire without coating.

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 (-20°C) J	KV (-30°C) J	KV (-40°C) J
EN ISO 14341-A-G 42/46 4 M21 3Si1	≥ 420 ≥ 460	≥ 500 ≥ 530	≥ 20	≥ 47	-	≥ 47
AWS A5.18 ER70S-6	≥ 400	≥ 480	≥ 22	-	≥ 27	-
PITTARC G6	≥ 420	≥ 500	≥ 22	≥ 47	≥ 47	≥ 47

Gas protection : ISO 14175 C1 (CO₂) / ISO 14175 M21 (80% Ar + 20% CO₂).

Classification : EN ISO 14341-A- **G 42 2 C1 3Si1** / EN ISO 14341-A- **G 42/46 4 M21 3Si1**

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

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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.

	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY										
 0036 06 ref. DoP PITTARC G6-2014-04 EN 13479:2004 Use in metallic structures or in composite metal and concrete structures	PITTARC G6										
	Welding wire for carbon steels and fine-grained steels EN ISO 14341-A – G 42/46 4 M21/ G42 2 C1 3Si1 and AWS A5.18 ER70S-6 Shielding gas according to ISO 14175 C1-M21 Current/Polarity G+, Welding positions: PA-PB-PC-PD-PE-PF-PG										
	APPROVALS: ABS, RINA, LRS, DNV, GL, BV, TUV Nr.07150, DB-Zul.-Nr. 42.044.01/01										
<table border="1"> <thead> <tr> <th>Weight kg</th> <th>Heat N°</th> <th>Diameter</th> <th>Spool type</th> </tr> </thead> <tbody> <tr> <td>XX</td> <td>XXXXX/XX</td> <td>X,X mm</td> <td>X XXX</td> </tr> </tbody> </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

ABS, RINA, LRS, DNV, GL, BV, TÜV, DB.

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