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**TECHNICAL SPECIFICATION
GMAW WELDING WIRE
PITTARC G9**

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1. DESCRIPTION

Gas shielded welding wire in according to standard UNI EN ISO 14341-A- G 4Si1 and AWS A5.18 ER70S-6, suitable to join fine grain steels for pressure vessels and construction. 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 G9	Min	0.06	1.60	0.80	-	-	-	-	-	-	-	-
	max	0.14	1.85	1.15	0.025	0.025	0.15	0.15	0.15	0.30	0.02	0.03
EN ISO 14341-A- G 4Si1	Min	0.06	1.60	0.80	-	-	-	-	-	-	-	-
	max	0.14	1.90	1.20	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- G46 4 M21 4Si1	≥ 460	≥ 530	≥ 20	≥ 47		≥ 47
AWS A5.18 ER70S-6	≥ 400	≥ 480	≥ 22		≥ 27	
PITTARC G9	≥ 460	≥ 530	≥ 22	≥ 47	≥ 47	≥ 47

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

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

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

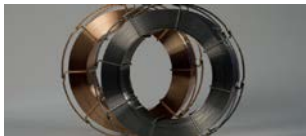
6. STANDARD PACKAGING.

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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	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY								
 0036 06 ref. DoP PITTARC G9-2014-04 EN 13479:2004 Use in metallic structures or in composite metal and concrete structures	<p style="text-align: center;">PITTARC G9</p> <hr/> Welding wire for carbon steels and fine-grained steels EN ISO 14341-A – G 46 4 M21/ 46 2 C1 4Si1 and AWS A5.18 ER70S-6 Shielding gas according to ISO 14175 M21-C1 Current/Polarity G+, Welding positions: PA-PB-PF-PG APPROVALS: ABS, LRS, DNV, GL, BV, TUV Nr.07152, DB-Zul.-Nr.42.044.02/01 <table border="0"> <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
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XX	XXXXXX/XX	X,X mm	X XXX						

8. STANDARD CERTIFICATION.

Documents according to EN 10204

9. APPROVALS

ABS, RINA, LRS, DNV, GL, BV, TÜV, DB.

