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SIAT

**TECHNICAL SPECIFICATION  
GMAW WELDING WIRE  
PITTARC G9Mo**

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**1. DESCRIPTION**

Gas shielded welding wire conforming to the standard UNI EN ISO 14341-A- G 50 4 M21 4Mo and AWS A5.28 ER80S-D2 suitable to join Mo low alloy steels for high 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+Zr
PITTARC G9Mo	Min	0.07	1.70	0.50	-	-	-	-	0.40	-	-	-	-
	Max	0.12	2.10	0.80	0.020	0.020	0.15	0.15	0.60	0.25	0.02	0.03	0.15
EN ISO 14341-A G4Mo	Min	0.06	1.70	0.50	-	-	-	-	0.40	-	-	-	-
	Max	0.14	2.10	0.80	0.025	0.025	0.15	0.15	0.60	0.35	0.02	0.03	0.15
AWS A5.28 ER80S-D2	Min	0.07	1.60	0.50	-	-	-	-	0.40	-	-	-	-
	Max	0.12	2.10	0.80	0.025	0.025	-	0.15	0.60	0.50	-	-	-

**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
AWS A5.28 ER80S-D2	≥ 470	≥ 550	≥ 17	27
EN ISO 14341-A- G 50 4 M21 4Mo	≥ 500	560 ÷ 720	≥ 18	≥ 47

Gas protection : ISO 14175 M21 mixture . Interpass temperature max 250°C

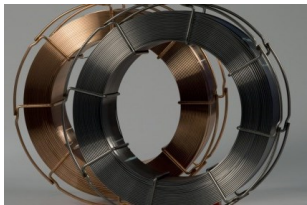
Recommended welding parameters (diam. 1,2 mm): 260÷300A; 25÷30V; wire feed speed ~5m/min; travel speed ~6mm/sec; tip to work ~20mm.

**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, and approvals.






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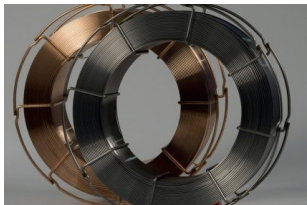
	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY		
<b>PITTARC G9Mo</b>			
Welding wire for carbon steels and fine grained steels EN ISO 14341-A – G 50 4 M21 4Mo and AWS A5.28 ER80S-D2			
Shielding gas according to ISO 14175 M21 Current/Polarity G+, Welding positions: PA, PB, PC, PF			
Weight kg	Heat N°	Diameter	Spool type
XX	XXXXX/XX	X,X mm	X XXX

## 8. STANDARD CERTIFICATION.

Documents according to EN 10204

## 9. APPROVALS

None



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