MG 2

Gas Metal Arc (MAG) Welding Wire - Non Alloyed Steels

Standards

AWS/ASME SFA - 5.18	ER70S-6
EN ISO 14341 - A	G 42 4 M21 3Si1
EN ISO 14341 - A	G 42 3 C1 3Si1
TS EN ISO 14341 - A	G 42 4 M21 3Si1
TS EN ISO 14341 - A	G 42 3 C1 3Si1
DIN M. No.	1.5125

Approvals & Certificates

TUV	TL	DB
CE-DoP	DNV	TSE
ABS	UKCA	CWB
RINA	CE	HAKC
UKCA-DoP	RMRS	

Materials

EN	DIN
S185 - P355T1	St 33 -St 52.0
S235JR - S355J0	St 37.2 - St 52.3
S235JR - S355J2	
P235G1TH - P265G1TH	St 35.8 - St 45.8
P235GH, P265GH	H I, H II
P235TR2 - P355T2	St 37.4 - St 52.4
E295	St 50.2
L210 - L360NB	StE 210.7 - StE 360.7
S255N -S380N	StE 255 - StE 380
GE 200 - GE 240	GS-38, GS-45
P295GH, P355GH	17Mn4, 19Mn5
-	A, B, D, E

Properties and Applications

Unalloyed wire electrode for GMA (MIG/MAG) welding of general structural steels, pipe steels, and cast steels using CO_2 or mixed shielding gases, depending on the thickness of the base metal. Commonly used in steel construction, shipbuilding, machinery, tank and boiler production, and the automotive industry. Preheating may be required depending on the plate thickness and the carbon equivalent of the base metal. A thin and homogeneous copper coating increases electrical conductivity and protects the wire from rusting.



Typical Chemical Features of the Welding Wire(%)

Type of Analysis	C	Si	Mn
Welding Wire	0.07	0.90	1.45

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	C1	430	540	29	-20°C → 90	-30°C → 70
As welded	M21	460	560	27	-30°C → 95	-40°C → 75

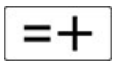
* Chemical compositon and mechanical properties are valid when using shielding gas EN ISO 14175 - C1 (%100 CO2) ve M21 (Ar + %20 CO2) .

Application Information

Welding Positions



Polarity:



Protection Gas:

M23 M20 M24 M26 M21 C1

Welding Parameters & Efficiency

Diameter (mm)	Current (A)
1.00	80-230
0.60	30-120
1.20	120-280
0.80	50-180
0.90	50-180
1.60	200-400

Packaging Information

Product Code	Diameter (mm)	Pieces per Box (~)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
21002AAKM2	0.60	1	1.0	10	10.7	Plastic Spool (D100)
21002ABBM2	0.60	5	5.0	1	5.3	Plastic Spool (D200)
21002AHAM2	0.60	12	12.0	1	12.6	Plastic Spool (D300)
21002AJAM2	0.60	12	12.0	1	12.7	Wire Basket Spool (K300MS)
21002AKAM2	0.60	12	11.5	1	12.6	Wire Basket Spool (K300MS)
21002B0JM2	0.80	60	60.0	1	64.0	Drum
21002B1JM2	0.80	250	250.0	1	257.5	Drum
21002B5IM2	0.80	60	60.0	1	64.0	Octabin
21002BAKM2	0.80	1	1.0	14	15.7	Plastic Spool (D100)
21002BBBM2	0.80	5	5.0	1	5.3	Plastic Spool (D200)
21002BHAM2	0.80	15	15.0	1	15.8	Plastic Spool (D300)
21002BHBM2	0.80	15	15.0	1	15.8	Plastic Spool (D300)
21002BJAM2	0.80	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002BJBM2	0.80	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002BKAM2	0.80	15	14.5	1	15.2	Wire Basket Spool (K300MS)
21002BNAM2	0.80	15	14.7	1	15.2	Wire Basket Spool (K300)
21002BNBM2	0.80	15	14.7	1	15.2	Wire Basket Spool (K300)
21002BRAM2	0.80	18	18.0	1	18.7	Wire Basket Spool (K300MS)
21002C1JM2	0.90	250	250.0	1	257.5	Drum
21002CALM2	0.90	1	1.0	14	15.7	Plastic Spool (D100)
21002CBBM2	0.90	5	5.0	1	5.3	Plastic Spool (D200)
21002CHAM2	0.90	15	15.0	1	15.8	Plastic Spool (D300)
21002CHBM2	0.90	15	15.0	1	15.8	Plastic Spool (D300)
21002CJAM2	0.90	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002CKAM2	0.90	15	14.5	1	15.2	Wire Basket Spool (K300MS)
21002CSAM2	0.90	20	20.0	1	20.9	Plastic Spool (D300)
21002D0JM2	1.00	60	60.0	1	64.0	Drum
21002D1JM2	1.00	250	250.0	1	257.5	Drum
21002D2HM2	1.00	400	400.0	1	416.0	Drum
21002DAKM2	1.00	1	1.0	14	15.7	Plastic Spool (D100)

21002DBBM2	1.00	5	5.0	1	5.3	Plastic Spool (D200)
21002DHAM2	1.00	15	15.0	1	15.8	Plastic Spool (D300)
21002DHBM2	1.00	15	15.0	1	15.8	Plastic Spool (D300)
21002DJAM2	1.00	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002DJBM2	1.00	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002DKAM2	1.00	15	14.5	1	15.2	Wire Basket Spool (K300MS)
21002DNAM2	1.00	15	14.7	1	15.2	Wire Basket Spool (K300)
21002DNBM2	1.00	15	14.7	1	15.2	Wire Basket Spool (K300)
21002DRAM2	1.00	18	18.0	1	18.7	Wire Basket Spool (K300MS)
21002E0JM2	1.20	60	60.0	1	64.0	Drum
21002E1JM2	1.20	250	250.0	1	257.5	Drum
21002E2HM2	1.20	400	400.0	1	416.0	Drum
21002EAKM2	1.20	1	1.0	14	15.7	Plastic Spool (D100)
21002EBBM2	1.20	5	5.0	1	5.3	Plastic Spool (D200)
21002EHAM2	1.20	15	15.0	1	15.8	Plastic Spool (D300)
21002EHBM2	1.20	15	15.0	1	15.8	Plastic Spool (D300)
21002EJAM2	1.20	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002EJAMT	1.20	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002EJBM2	1.20	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002EKAM2	1.20	15	14.5	1	15.2	Wire Basket Spool (K300MS)
21002ENAM2	1.20	15	14.7	1	15.2	Wire Basket Spool (K300)
21002ENBM2	1.20	15	14.7	1	15.2	Wire Basket Spool (K300)
21002ERAM2	1.20	18	18.0	1	18.7	Wire Basket Spool (K300MS)
21002ESAM2	1.20	20	20.0	1	20.9	Plastic Spool (D300)
21002F1JM2	1.40	250	250.0	1	257.5	Drum
21002FHAM2	1.40	15	15.0	1	15.8	Plastic Spool (D300)
21002FHBM2	1.40	15	15.0	1	15.8	Plastic Spool (D300)
21002FJAM2	1.40	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002FJBM2	1.40	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002G0JM2	1.60	60	60.0	1	64.0	Drum
21002G1JM2	1.60	250	250.0	1	257.5	Drum
21002G2HM2	1.60	400	400.0	1	416.0	Drum
21002GEBM2	1.60	5	5.0	1	5.3	Plastic Spool (D200)
21002GHAM2	1.60	15	15.0	1	15.8	Plastic Spool (D300)
21002GHBM2	1.60	15	15.0	1	15.8	Plastic Spool (D300)
21002GJAM2	1.60	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002GJBM2	1.60	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002GKAM2	1.60	15	14.5	1	15.2	Wire Basket Spool (K300MS)
21002GNAM2	1.60	15	14.7	1	15.2	Wire Basket Spool (K300)
21002HJAM2	2.00	15	15.0	1	15.7	Wire Basket Spool (K300MS)
21002I2HM2	2.40	400	400.0	1	416.0	Drum
21002L2HM2	3.20	400	400.0	1	416.0	Drum

Storage & Re-Drying Information

Shouldn t be exposed to high statical load and impact.