LE SG2

CLASSIFICATION

AWS A5.18 ER70S-6
TS EN ISO 14341-A G 42 3 C G3Si1 / G 42 4 M G3Si1

GENERAL DESCRIPTION

LE SG2 is a copper coated gas metal arc welding wire in 15 kg spools or 250 kg drums. It is particularly designed for semiautomatic and full-automatic GMAW applications. Working temperature can range between –50 to 450°C.

CO_2 or 80 % Ar + 20 % CO_2 are used for gas shielding.

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Si	Mn
0.08	0.85	1.50
0.06*	0.55*	1.10*

(*) Typical weld metal composition (CO_2 gas shielding)

APPROVALS (with flux LW-860)

CE, DB, GOST, NAKS, SEPRO, TSE, TÜV

ABS (3SA,3YSA) **BV** (3YM) **DNV-GL** (IIIYMS) **LRS** (3S 3YS H15) **RINA** (3Y42) **RMRS** (3Y) **TL** (3YMS) CO_2 gas shielding
ABS (3YSA) **DNV-GL** (IIIYMS) **TL** (3YMS) Ar+CO_2 gas shielding

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield strength (N/mm²)	Tensile strength (N/mm²)	Elongation (L=5d) (%)	Impact (ISO-V) (J) -30°C
440	540	30	60

SHIELDING GASES (ISO 14175/ EN 439)

MAG M21- Ar + 5-25% CO_2
C1 - CO_2 (100%)

Current Type and Polarity: DC (+)

EXAMPLES OF MATERIALS TO BE WELDED

	DIN	EN
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52, St 52-3 St 37-4, St 44-4, St 52-4 St 50-2, St 60-2 C 10 - C 35 ; Ck 10 - Ck 35	S185, S235, S275, S355 P235TR2 - P355T2 E295, E335 C10 - C35
Fine Grained Steels	StE 255 - StE 460 WStE 255 - WStE 355	S255N - S420N P255NH - P355NH
Pipe Materials	StE 210-7 - StE 415-7 StE 290-7 TM -S tE 360-7 TM X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 HI, HII	P295GH, P355GH P235GH, P265GH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, C, D, E AH32 - EH36	- -
Cast Steels	GS-38, GS-45, GS-52	GE200, GE240, GE260

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight	Drum Weight
MIG/MAG Wire	X	X	X	X	-	-	-	15 kg	250 kg