

Wire type:
TIG Solid wire

Current:



Welding positions:



Shielding gas:

I1

Fer SG1 is our copper coated wire for TIG welding unalloyed and low alloyed, incl. fine grain types, and structural steels. Typical applications include: general constructions, shipbuilding, bridges, tanks and is extremely suited for joining thin sheet metals. To be used in combination with tungsten electrodes type WS2 WITSTAR®.

Base materials to be welded:

- Ships plate A-D, A(H)32-D(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2, St.33-St.52, C(K)10-C(K)35
- Boiler steel P235GH-P295GH, HI, HII, 17Mn4
- Fine grain steel P275N-P355N, S275N-S355M, StE285-StE 355, StE285-StE355TM
- Pipe steel P235T1-P355N, L210-L360NB, St37.0-St52, St45.8, X42-X52, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

Applications:

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance

Chemical composition, wt.% weld metal – typical:

C	Mn	Si
0,09	1,15	0,60

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 420	≥ 510	≥ 22	-20°C ≥ 100

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
1,6	1000	5
2,0	1000	5
2,4	1000	5
3,0	1000	5