

Wire type:
TIG Solid wire

Current:



Welding positions:



Shielding gas:

I1

Fer SG1A is our copper coated wire for TIG welding unalloyed and low alloyed galvanized structural steels. We have added Ti, Zr and Al to the wire, this makes Fer SG1A ideal for welding oxidized (rusted) material and also coated plate (primed or painted). To be used in combination with tungsten electrodes type WS2 WITSTAR®.

Base materials to be welded:

- Ships plate A-E, A(H)32-E(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2G3, St.33-St.52.3, C(K)10-C(K)35
- Boiler steel P235GH-P355GH, HI, HII, 17Mn4, 19Mn6
- Fine grain steel P275N-P355NL2, S275N-S420N, StE285-ES285, StE285TM-ES285TM
- Pipe steel P235T1-P355N, L210-L415MB, St37.0-St52.4, St45.8, X42-X60, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

Applications:

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance
- Transport & Lifting Industry

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	Ti	Zr	Al
0,06	1,10	0,50	0,10	0,07	0,10

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 480	≥ 560	≥ 22	-20°C ≥ 47

Packaging data:

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