

Wire type:
TIG Solid wire

Current:



Welding positions:



Shielding gas:

I1

Fer SG2 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 etc. 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-EStE355, StE285TM-EStE355TM
- 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
0,09	1,47	0,87

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 460	≥ 500	≥ 22	-50°C ≥ 47

Packaging data:

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