

# GM 70G

## IDENTIFICATION

GM 70G, ER 70G

## CLASSIFICATION

AWS/SFA 5.18: ER 70G

## DESCRIPTION

- General purpose MIG Welding wire for welding of plates, pipes and tubes.
- Smooth flow, gives shiny welds of radiographic quality.

## CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cu
0.10 max	1.30 - 1.70	0.40 - 0.75	0.03 max	0.03 max	0.50 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
500 - 600	430 - 540	24 - 30	20°C	80 - 140 J
			0°C	60 - 120 J

## TYPICAL APPLICATIONS

- General purpose MIG welding of the following grades of steel in the form of plates, pipes and tubes.
- ASTM A-285 Gr. C, A-515 Gr. 60, A-515 Gr. 70, A-516 Gr. 60 / Gr. 70
- DIN 17155 Gr. II, Gr. III, Gr. IV, etc.
- ASTM A-106 Gr. B, A-53 Gr. B etc
- ASTM A-179, ASTM A-214, etc

**SHIELDING GAS** : CO<sub>2</sub> / Argon +15~25% CO<sub>2</sub> gas mixture.

## PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	15
1.2	15
1.6	15