

ROMIG-70SG

COPPER COATED CONTINUOUS OR CUT LENGTH
SOLID WIRE FOR TIG/MIG WELDING

DIN 8559: SG3
BASIC ALLOY: FE, MN, SI
AWS: SFA/A 5.18: ER70S-G
EN ISO 14341-B G 49A Z C SZ

KEY FEATURES:

A copper coated, manganese-silicon alloyed GTAW wire for welding of all general engineering and structural steels with minimum yield strength of max 400 MPa High levels of silicon and manganese for use on slightly contaminated base materials

APPLICATIONS

- low alloys steels and piping and boiler, • suitable all kind of 500 MPA steels structural • containers and offshore structures.

SHEILDING GAS:

- MIG welding with CO2 gas and Ar+ CO2 gas mixture, TIG welding with Argon gas

CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Cu
0.07-0.15	1.50-1.90	0.60-1.00	0.035 Max	0.025 Max	0.50 Max

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @
400 min.	500 min.	22 min.	Minus 30C : 80-100J

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR MIG WELDING)

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min	Spool packing 12.5 kg	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	✓	✓	X
1.20	0.047	150-300	24-34	15-25	✓	✓	✓
1.60	1/16"	150-350	28-36	15-30	✓	✓	✓

DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR TIG WELDING)

Size (mm)	Size (inch)	Length (mm)	Length (Inch)	Current Condition (DC-)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	40-80	10-16	✓	✓
2.0	5/ 64"	1000	36"	50-100	12-18	✓	✓
2.4/ 2.5	3/ 32"	1000	36"	60-120	14-20	✓	✓
3.2	1/ 8"	1000	36"	100-150	16-24	✓	✓
4.0	5/ 32	1000	36"	140-200	18-28	✓	✓