

ROMIG-80SG

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

DIN 8559: SG4MO
BASIC ALLOY: FE, MN, SI, MO
AWS: SFA/A 5.28: ER80SG
EN ISO 14341-B G 55A C1 Z 4MO

KEY FEATURES:

ER80SG copper-coated solid wire for GMAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. Thin and uniform copper coating ensure good Conductivity useful for high speed feeding.

APPLICATIONS

Suitable for carbon steel and low alloy Steel. • It is suitable for welding high strength fine-grained structural steels containing ~0.5%Mo . ASTM grade SA-36,SA-36M and SA-283 SA-283M

SHEILDING GAS:

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

CHEMICAL COMPOSITION:

C	Mn	Si	S & P	Mo	Cu
0.06-0.15	1.40-2.10	0.40-0.90	0.030 Max	0.40-0.60	0.50 Max

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @
500 min.	550 min.	20 min.	Minus 30C : 80-100 J

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	✓	✓