MG 201

Gas Metal Arc (MAG) Welding Wire - Creep Resisting Steels

Standards

AWS/ASME SFA - 5.28	ER70S-A1
AWS/ASME SFA - 5.28	ER80S-G
EN ISO 21952 - A	G MoSi
TS EN ISO 21952 - A	G MoSi
DIN M. No.	1.5424

Approvals & Certificates

CE TUV

Materials

Width	DIN
S255N - S420N	StE 255 - StE 420N
P235G1TH - P255G1TH	St 35.8 - St 45.8
P295GH, P355GH	17Mn4, 19Mn5
16Mo3	15Mo3
P235GH, P265GH	H I , H II
L360NB - L415NB	StE 360.7 - StE 415.7
	X52, X60

Properties and Applications

Low alloyed wire electrode for GMA (MIG/MAG) welding of creep resistant boiler and pipe steels subjected to operating temperatures up to 530°C. Also suitable for joining C-Mn steels, which will be postweld heat treated. CO_2 or mixed shielding gases can be used depending on the thickness of the base metal. A thin and homogeneous copper coating increases electrical conductivity and protects the wire from rusting.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Mo
Welding Wire	0.10	0.60	1.20	0,50

Typical Mechanical Values of Weld Metal

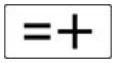
Test Condition	Protection Gas	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	M21	500	600	23	20°C → 100	0°C → 50

* Chemical compositon and mechanical properties are valid when using shielding gas EN ISO 14175 - M21 (%82 Ar + %18 CO2) .

Application Information

Welding Positions

Polarity:



Protection Gas:

M20 M21 C1

Welding Parameters & Efficiency

Diameter (mm)
0.80
1.00
1.20
1.60

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
22000BJAM2	0.80	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22000D1GM2	1.00	250 kg	261.00	1	261.00	Fiber Drum
22000DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22000EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22000GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn t be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.