

1. DESCRIPTION

Gas shielded welding wire conforming to the standard UNI EN ISO 14341-A- G 4Mo and AWS A5.28 ER80S-D2 suitable to join Mo low alloy steels for high temperature applications. Available in copper coated wire, standard and "Innov-Arc", and in no-copper wire, "Green-Arc".

2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	V	Ti+Zr
PITTARC G9Mo	Min	0.07	1.70	0.50	-	-	-	-	0.40	-	-	-	-
	Max	0.12	2.10	0.80	0.020	0.020	0.15	0.15	0.60	0.25	0.02	0.03	0.15
EN ISO 14341-A-G 4Mo	Min	0.06	1.70	0.50	-	-	-	-	0.40	-	-	-	-
	Max	0.14	2.10	0.80	0.025	0.025	0.15	0.15	0.60	0.35	0.02	0.03	0.15
AWS A5.28 ER80S-D2	Min	0.07	1.60	0.50	-	-	-	-	0.40	-	-	-	-
	Max	0.12	2.10	0.80	0.025	0.025	-	0.15	0.60	0.50	-	-	-

3. WIRE DIMENSIONS

Standard diameter (mm): 0.8; 1.0; 1.2; 1.4; 1.6
Permissible deviations: ISO 544

4. CAST AND HELIX (STANDARD PACKAGING)

Cast (mm): 800 ÷ 1000
Helix (mm): maximum 10

5. ALL-WELD-METAL MECHANICAL PROPERTIES

	Re MPa	Rm MPa	A5 %	KV (-40°C) J
AWS A5.28 ER80S-D2	≥ 470	≥ 550	≥ 17	≥ 27
EN ISO 14341-A- G 50 4 M21	≥ 500	560 ÷ 720	≥ 18	≥ 47

Gas protection: ISO 14175 M21 mixture. Interpass temperature max 250°C.

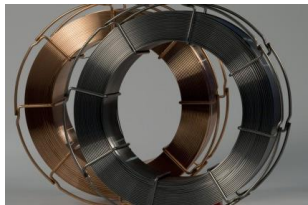
Recommended welding parameters (diam. 1,2 mm): 260÷300A; 25÷30V; wire feed speed ~5m/min; travel speed ~6mm/sec; tip to work ~20mm.

6. STANDARD PACKAGING



Wire basket rim RG (ISO 544 B300) of 18 kg net weight. Each spool sealed in a polyethylene airtight bag and packed into a cardboard box. 72 spools stacked onto a pallet secured by thermoplastic shrink-wrapping (94x125x80 cm, 1296kg net weight). Available cardboard drums of about 250kg net weight, each one stacked onto a pallet 105x105x90 cm of about 1000kg total weight, secured by thermoplastic shrink-wrapping. On request packaging available from 15 kg up to 700 kg.

7. STANDARD IDENTIFICATION

A label is attached to the inside of each spool containing nominal diameter, trade name, classification, heat number, operator code. A label is attached to every box containing manufacturer, trade name, nominal diameter, heat number, spool type, references to the standards, CE mark and approvals.



**SGQ
SIAT S.p.A**

 PITTARC	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY										
 0036 06 ref. DoP PITTARC G9Mo-2020-10 EN 13479:2017 Use in metallic structures or in composite metal and concrete structures	<div style="text-align: center;">PITTARC G9Mo</div> <hr/> Welding wire for carbon steels and fine-grained steels EN ISO 14341-A – G50 4 M21 4Mo and AWS A5.28 ER80S-D2 Shielding gas according to ISO 14175 M21 Current/Polarity G + , Welding positions: PA, PB, PC, PF <table border="0" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: left;">Weight kg</th> <th style="text-align: left;">Heat N°</th> <th style="text-align: left;">Diameter</th> <th style="text-align: left;">Spool type</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">XX</td> <td style="text-align: center;">XXXXX/XX</td> <td style="text-align: center;">X,X mm</td> <td style="text-align: center;">X XXX</td> </tr> </tbody> </table>			Weight kg	Heat N°	Diameter	Spool type	XX	XXXXX/XX	X,X mm	X XXX
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8. STANDARD CERTIFICATION

Documents according to EN 10204.

9. APPROVALS

None.

