

# AX-SGZinc 1.5112

## Standard

EN ISO 14341-A	G 2Ti (Wire)
EN ISO 14341-A	G 42 3 M22 2Ti
EN ISO 14341-B	G 49A 3 M22 S2
Material number:	1.5112
AWS A5.18	ER70S-G

## Area of application

Wire electrode of low-alloyed steel for MAG welding of unalloyed and low-alloyed steels. Particularly suitable for overwelding prefabrication primers and protective zinc coatings. Non-ageing weld metal for operating temperatures of  $-10\text{ }^{\circ}\text{C}$  to  $450\text{ }^{\circ}\text{C}$ .

## Special hints

The wire electrode is matched to mixed gases M 33 and M 23. Particularly suitable for welding galvanized, primed or slightly rusty components. The weld metal is non-ageing under mixed gases M 21 and M 33.

## Composition of the wire electrode (typical data in %)

C	Si	Mn	Al	Zr	Ti		
0.07	0.8	1.4	0.1	<0.1	0.1		

## Important base materials

S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S420N, S275M-S420M, P235GH-P355GH, P355N, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L245MB-L415MB, shipbuilding steels: A, B, D, E, A 32-E 36  
 ASTM A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 283 Gr. B, C, D; A 501 Gr. B; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 662 Gr. A, B; A 709 Gr. 36, 50; A 711 Gr. 1013; API 5 L B, X42, X52, X60

## Material properties

Welding process	MAG	Mechanical properties of the weld metal according to EN ISO 15792-1
Shielding gas	M21	
Test temperature	20°C	
0.2%-yield strength $R_{p0.2}$	[MPa]	430
Tensile strength $R_m$	[MPa]	520
Elongation $A (L_0 = 5d_0)$ %	[%]	24
Impact strength $A_v$	[J]	90

## Applicable shielding gases (EN ISO 14175)

MAG:  $\text{CO}_2$  or mixed gases e.g. M22, M33, M21, M23

## Approvals

(Request current scope if required)

## Product forms

Spool	Ø mm	0.8	1.0	1.2	1.6		
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