

| Description | Classifications |
|-------------|-----------------|
|-------------|-----------------|

SG2 is a general purpose copper-coated solid wire suitable for many carbon steel welding applications using the MIG/Gas Metal Arc Welding (GMAW) processes.

SG2 contains moderate amounts of manganese and silicon to provide sufficient deoxidation over light mill scale.

Shielding gas choices for SG2 in the GMAW mode are 100% carbon dioxide, argon/carbon dioxide mixtures, argon/oxygen mixtures, and other argon based mixed gas blends.

SG2 is used in a wide variety of applications including heavy equipment, automotive parts, railcars, agricultural equipment, and sheet metal welding. pressure vessel fabrication and shipbuilding.

Suitable for use over light rust.

The wire has a carefully controlled wire chemistry and a unique surface technology providing superior weld-metal quality at high wire feed speeds and at high welding currents. The wire can be used with both Ar/CO2 mixed gas and pure CO2 shielding gas.

DIN 8559      SG2  
 SFA/AWS A5.18 ER70S-6  
 EN ISO 14341    G42 2 C1 / G42 4 M21 3Si1

| Wire Composition |
|------------------|
|------------------|

| C    | Si   | Mn   | Mo   | S     | P    |
|------|------|------|------|-------|------|
| 0.08 | 0.90 | 1.50 | 0.05 | 0.015 | 0.02 |

| Typical Mech. Properties All weld metal |
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|---|

|                  |     |     |
|------------------|-----|-----|
| Yield Stress     | Mpa | 470 |
| Tensile Strength | Mpa | 560 |
| Elongation       |     | %26 |



| Welding Current | Approvals |    |    |     |     |    |
|-----------------|-----------|----|----|-----|-----|----|
| DC (+)          | ABS 3YS   | CE | DB | TUV | CCS | LR |

| Welding Parameters |
|--------------------|
|--------------------|

| Diameter (mm) | Wire feed (m/min) | Welding current (A) | Voltage (V) | Wire Reference |
|---------------|-------------------|---------------------|-------------|----------------|
| 0.6           | 5.5-13            | 30-100              | 15-20       | TY G3Si1       |
| 0.8           | 3.2-13            | 60-200              | 18-24       | TY G3Si1       |
| 0.9           | 3.0-15            | 70-250              | 18-26       | TY G3Si1       |
| 1.0           | 2.7-15            | 80-300              | 18-32       | TY G3Si1       |
| 1.2           | 2.5-15            | 120-380             | 18-34       | TY G3Si1       |
| 1.6           | 2.3-12            | 225-550             | 28-38       | TY G3Si1       |

|   |
|---|
| IN 15 KGS PLASTIC OR STEEL SPOOL, WITH PRECISION WINDING, IN 250 KGS DRUM PACK FOR DIAM. 1.0MM, 1.2MM<br>AVAILABLE IN DIAM. 0.6MM, 0.8MM. IN PLASTIC SPOOL OF 5 KGS |
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