

# EZ - SG Ti

## CLASSIFICATION

EN ISO 14341-A	AWS / ASME SFA-5.28
G 42 2 C/M 2Ti	ER70S-2

## DESCRIPTION AND APPLICATION

A copper or bronze coated solid wire alloyed with titanium for welding of carbon and carbon-manganese steels with tensile strength up to 510 N/mm<sup>2</sup>. Due to it's titanium addition it is suitable for single-pass welding of galvanized, primer coated or oxidized steels.

Steel grade	HRN (stari)	DIN (W. Nr.)	
Constructional steels	Č 0261 do Č 0545	St 33 (1.0035) do St 52-2N (1.0050)	
Boiler steels	Č 1202    Č 1204 Č 3133    Č 3105	HI (1.0345) 17Mn4 (1.0481)	HII (1.0425) 19Mn6 (1.0473)
Tube and pipe steels	Č 1212 do Č 3100	St 35.8 (1.0305) do St 45.8 (1.5415)	

## MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R <sub>eL</sub> N/mm <sup>2</sup>	R <sub>m</sub> N/mm <sup>2</sup>	A <sub>5</sub> %	KV (-20°C) J
> 430	540 - 640	> 20	≥ 47

## APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Si	Mn	Ti
%	0,05 - 0,08	0,5 - 0,8	1,1 - 1,5	0,08 - 0,12

## SHIELDING GAS

C1 ili M21

## PACKAGING

Wire diameter mm	Winding
0,8; 1,0; 1,2	precision-wound (S-S)
15 kg - metal spool (S-S)	

## APPROVALS

DB; TÜV

