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**TECHNICAL SPECIFICATION
GMAW WELDING WIRE
PITTARC G3Ni1**

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1. DESCRIPTION

Gas shielded welding wire conforming to the standard UNI EN ISO 14341-A- G 50 4 M21 3Ni1 and AWS A5.28 ER80S-Ni1 suitable to join Ni low alloy steels for low temperature applications. Available in copper coated wire and **no-copper** wire.

2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	V	Ti+Zr
PITTARC G3Ni1	Min	0.07	1.00	0.60	-	-	-	0.80	-	-	-	-	-
	Max	0.12	1.20	0.80	0.020	0.020	0.15	1.00	0.15	0.20	0.02	0.03	0.15
EN ISO 14341-A G3Ni1	Min	0.06	1.00	0.50	-	-	-	0.80	-	-	-	-	-
	Max	0.14	1.60	0.90	0.020	0.020	0.15	1.50	0.15	0.35	0.02	0.03	0.15
AWS A5.28 ER80S-Ni1	Min	-	-	0.40	-	-	-	0.80	-	-	-	-	-
	Max	0.12	1.25	0.80	0.025	0.025	0.15	1.10	0.35	0.35	-	0.05	-

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-Ni1	≥ 470	≥ 550	≥ 24	27
EN ISO 14341-A- G 50 4 M21 3Ni1	≥ 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, and approvals.



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	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY
PITTARC G3Ni1	
Welding wire for carbon steels and fine grained steels EN ISO 14341-A – G 50 4 M21 3Ni1 and AWS A5.28 ER80S-Ni1	
Shielding gas according to ISO 14175 M21 Current/Polarity G+, Welding positions: PA, PB, PC, PF	
Weight kg	Heat N°
XX	XXXXX/XX
Diameter	Spool type
X,X mm	X XXX

8. STANDARD CERTIFICATION.

Documents according to EN 10204

9. APPROVALS

None

