



SAQ
SIAT

TECHNICAL SPECIFICATION
GMAW WELDING WIRE
PITTARC GMo

Document SPP114
Revision 08 i
Date 18.09.2014
Page 1/2

1. DESCRIPTION

Gas shielded welding wire conforming to standard ISO 14341-A-G 2Mo and AWS A5.28 ER70S-A1 suitable to join common steels and Mo low alloy steel for construction, pressure vessels and pipes. Particularly suitable to join steels resistant to hot creep up to 500°C and for tack weld in pipe production.

2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	V	Ti+Zr
PITTARC GMo	Min	0.08	0.90	0.30	-	-	-	-	0.40	-	-	-	-
	Max	0.12	1.30	0.70	0.020	0.020	0.15	0.15	0.60	0.35	0.02	0.03	0.15
ISO 14341-A G 2Mo	Min	0.08	0.90	0.30	-	-	-	-	0.40	-	-	-	-
	Max	0.12	1.30	0.70	0.020	0.020	0.15	0.15	0.60	0.35	0.02	0.03	0.15
AWS A5.28 ER70S-A1	Min	-	-	0.30	-	-	-	-	0.40	-	-	-	-
	Max	0.12	1.30	0.70	0.025	0.025	-	0.20	0.65	0.35	-	-	-

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 (+20) J
AWS A5.28 ER70S-A1	≥ 400	≥ 515	≥ 19	-
ISO 14341-A-G 42 A M21 2Mo	≥ 420	≥ 500	≥ 20	≥ 47
PITTARC GMo	≥ 420	≥ 515	≥ 20	≥ 47

Gas protection : ISO 14175 M21 mixture (80% Ar + 20% CO₂). Preheating and interpass: <

All data/information of this document are only at informative title and not binding for SIAT S.p.A., who entitles full right to modify/change them without prior notice.



SAQ
SIAT

TECHNICAL SPECIFICATION
GMAW WELDING WIRE
PITTARC GMo

Document SPP114
Revision 08 i
Date 18.09.2014
Page 2/2

200 °C

Classification : ISO 14341-A- G 42 A M21 2Mo

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.

8. STANDARD CERTIFICATION.

Documents according to EN 10204

 PITTARC		SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY	
PITTARC GMo			
Welding wire for carbon steels and fine-grained steels EN ISO 14341-A – G 42 A M21 2Mo and AWS A5.28 ER70S-A1			
Shielding gas according to ISO 14175 M21-C1			
Current/Polarity G+, Welding positions: PA-PB-PC-PD-PE-PF-PG			
Weight kg	Heat N°	Diameter	Spool type
XX	XXXXX/XX	X,X mm	X XXX

9. APPROVALS

NONE

SIAT – Società Italiana
Acciai Trafilati S.p.A.
Via Facini, 54
33013 Gemona del Friuli
(Ud)
Tel.: +39 0432 062911
Fax: +39 0432
www.pittini.it

All data/information of this document are only at informative title and not binding for SIAT S.p.A., who entitles full right to modify/change them without prior notice.

