



SAQ
S.I.A.T.
sec. Pittarc

TECHNICAL SPECIFICATIONS
GMAW WELDING WIRE
TRADE NAME : PITTARC GTA

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1. DESCRIPTION

Gas shielded welding wire conforming to the standard UNI EN ISO 16834-A- G69 4M Mn3Ni1CrMo and AWS A5.28 ER110S-G suitable to join high strength and Cr-Ni-Mo low alloy steels. Available in copper coated wire and **no-copper** wire.

2. PRODUCT CHEMICAL COMPOSITION (in %)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	V	Ti
PITTARC GTA	Min	0.08	1.60	0.50	-	-	0.30	1.40	0.24	-	-	0.08	-
	Max	0.11	1.80	0.70	0.015	0.018	0.40	1.60	0.30	0.35	0.12	0.13	0.10
EN ISO 16834-A- Mn3Ni1CrMo	Min	-	1.30	0.40	-	-	0.20	1.20	0.20	-	-	0.05	-
	Max	0.12	1.80	0.70	0.015	0.018	0.40	1.60	0.30	0.35	0.12	0.13	0.10

3. WIRE DIMENSIONS

Standard diameter (mm) : 1.0 ; 1.6
Permissible deviations : ISO 544

4. CAST AND HELIX (SPOOL STANDARD PACKAGING)

Cast (mm) : 700÷1200
Helix (mm) : maximum 25

5. ALL-WELD-METAL MECHANICAL PROPERTIES

	Re MPa	Rm MPa	A5 %	KV (-40°C) J
AWS A5.28 ER110S-G	(≥ 660)	≥ 760	(≥ 15)	-
EN ISO 16834-A- G 69 4M Mn3Ni1CrMo	≥ 690	770 ÷ 940	≥ 17	≥ 47
PITTARC GTA	≥ 690	≥ 770	≥ 17	≥ 47

Gas protection : ISO 14175 M21 mixture . Preheating and interpass temperature: 120 ÷ 180 °C

Recommended welding parameters (diam. 1,2 mm): 250÷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, standards and CE mark.

	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY			
 0036 06 0036 – CPD – S009 EN 13479 + EN ISO 16834	PITTARC GTA			
	Welding wire for high strength steels EN ISO 16834 -A- G69 4M Mn3Ni1CrMo and AWS A5.28 ER110S-G Shielding gas according to ISO 14175 M21 Current/Polarity G+, Welding positions: PA, PB, PF			
	APPROVALS : TUV			
	Weight kg XX	Heat N° XXXXXX/XX	Diameter X,X mm	Spool type X XXX

8. STANDARD CERTIFICATION : Documents according to EN 10204

9. APPROVALS: TÜV