

# GB-74 EcoPac Mini™ MIG/MAG welding wire in drum



GB-74 EcoPac Mini™ is the latest addition and a perfect option for manufacturers using moderate volumes of wire, and who want to avoid tying up capital in large drums, but still get the benefits of short downtime and high productivity. The thread in GB-74 EcoPac Mini™ has the same unique welding characteristics as its larger colleague GB-74 EcoPac™, and is specifically designed to fit applications with high demands on pore safe welds and good feeding characteristics. All drums are manufactured from environmentally friendly cardboard and therefore are 100% recyclable. Packing welding wire in drums increase efficiencies along the entire weld chain in the form of effective management - reduced down time - reduced waste - increased process stability - improved weld quality, which lead to cost savings in the entire welding process.

Like our other products, it is characterized by a high quality copper layers, tight dimensional tolerances and absolute purity, resulting in a precise and reliable wire feeding for both manual and automated welding.

As all our wire GB-74 EcoPac Mini™ is manufactured under a controlled process, and here we have used our extensive experience in the wire know-how to provide a product with unique features. Our specially developed manufacturing process ensures a product with stringent quality standards, which means that GB-74 EcoPac™ always has the same excellent features.



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## Product information

| Dimension / Weight |           | Welding characteristics |             |              |
|--------------------|-----------|-------------------------|-------------|--------------|
| Dim. (mm)          | D100 (kg) | Welding current         | Arc voltage | Wire feeding |
| 0,80               | Aprox.    | 70-185 A                | 18-24 V     | 6-10 m/min   |
| 0,90               | Aprox.    | 80-250 A                | 18-26 V     | 6-12 m/min   |
| 1,00               | Aprox.    | 100-300 A               | 18-32 V     | 6-15 m/min   |
| 1,20               | Aprox.    | 120-380 A               | 18-34 V     | 7-13 m/min   |
| 1,40               |           | 150-420 A               | 28-36 V     | 7-12 m/min   |
| 1,60               |           | 225-550 A               | 28-38 V     | 7-12 m/min   |

### Wire composition:

|                       | C         | Si      | Mn      |
|-----------------------|-----------|---------|---------|
| SS-EN 14341 G3Si1 (%) | 0,06-0,14 | 0,7-1,0 | 1,3-1,6 |
| Typical value (%)     | 0,08      | 0,9     | 1,4     |

### Welding current:

DC+

### Shield gas:

CO<sub>2</sub> 25%, Ar 75%, 7-12 l/minCO<sub>2</sub> 100%, 7-12 l/min

### Mechanical properties:

Values for fully welded test bars with CO<sub>2</sub> 25% and Ar 75% as shield gas.

|                                  | Requirements<br>SS-EN 14341 G3Si1 | Typical<br>values |
|----------------------------------|-----------------------------------|-------------------|
| Tensile strength (Mpa)           | 500-640                           | 580               |
| Yield strength (Mpa)             | > 420                             | 480               |
| Elongation (%)                   | > 20                              | 28                |
| Impact value ft-ibs (J) at -20°C | > 47                              | 108               |
| Impact value ft-ibs (J) at -40°C |                                   | 81                |

### Packaging:

GB-74 EcoPac Mini™ is delivered in drums made of environmentally friendly wood fiber and is totally recyclable. For trouble free production we recommend our special developed despooling equipment GB-9775, which comes complete with hood, linear and necessary couplings. For smooth handling and change of drums we recommend our trolley GB-9776, and our lifting device GB-9799.

| Packaging         | Pcs/pallet | ØD (mm) | H (mm) |
|-------------------|------------|---------|--------|
| D100 EcoPac Mini™ | 8          | 520     | 430    |

### Approvals:

DNV GL  
Deutsche Bahn  
Lloyds Register of Shipping  
TÜF

### Classification:

SS-EN 14341 G3Si1

### Quality:

Grytgöls Bruk is certified according to  
SS-EN ISO 9001:2015.



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