

# GB-76 EcoPac Mini™

## MIG/MAG welding wire in drums



GB-76 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-76 EcoPac Mini™ has the same unique welding characteristics as its larger colleague GB-76 EcoPac™, with increased silicon and manganese content and is specifically designed to fit applications with high demands on pore safe welds and good feeding characteristics.

The octagonal shape makes it unique, the empty drum can be folded, providing great space saving compared to standard circular drums.

All drums are manufactured from environmentally friendly cardboard with no metal parts 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, GB-76 EcoPac Mini™ 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.

GB-76 EcoPac Mini™ is manufactured at our plant in Grytgöl, Sweden, 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-76 EcoPac™ always has the same excellent features.



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**Product information:**

Dimension / Weight		Welding characteristics		
Dim. (mm)	W60 (kg)	Welding current	Arc voltage	Wire feeding
0,80	Aprox. 60	70-185 A	18-24 V	6-10 m/min
0,90	Aprox. 60	80-250 A	18-26 V	6-12 m/min
1,00	Aprox. 60	100-300 A	18-32 V	6-15 m/min
1,20	Aprox. 60	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 G4Si1 (%)	0,06-0,14	0,8-1,2	1,6-1,9
Typical value (%)	0,07	0,9	1,65

**Approvals:**Deutsche Bahn  
TÜF**Welding current:**

DC+

**Classification:**

SS-EN 14341 G4Si1

**Shield gas:**CO<sub>2</sub> 25%, Ar 75%, 7-12 l/min.CO<sub>2</sub> 100%, 7-12 l/min.**Quality:**

Grytgöls Bruk is certified according to SS-EN ISO 9001:2008.

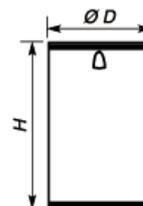
**Mechanical properties:**Values for fully welded test bars with CO<sub>2</sub> 25% and Ar 75% as shield gas.

	Requirements SS-EN 14341 G4Si1	Typical values
Tensile strength (Mpa)	500-640	610
Yield strength (Mpa)	> 420	515
Elongation (%)	> 20	29
Impact value ft-ibs (J) at -20°C	> 47	97
Impact value ft-ibs (J) at -40°C		83

**Packaging:**

GB-76 EcoPac Mini™ is delivered in drums made of environmental friendly cardboard. The special EcoPac consists of no metallic parts 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	∅D (mm)	H (mm)
W60 EcoPac Mini™	8	520	430

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