

GB-74 EcoPac™

MIG/MAG welding wire in drum



GB-74 EcoPac™ is a silicon-manganese alloy, copper-coated welding wire for MIG/MAG welding in non alloy and low-alloy steels.

This packaging form is particularly suitable for high-consumption applications requiring continuous operation, e.g. robotic welding and other mechanized applications.

Drums are available as 250 kg or 450 kg, which leads to greatly increased productivity, with a minimum of downtime, e.g. for maintenance and wire changes. It also offers the possibility of running unmanned shifts or production with reduced manning.

The wire is layer wound in the drum using a special method allowing it to be fed out through the welding gun without rotating them. The straight wire makes for more reliable starts and wire feed and precise positioning of the welded joint.

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.

GB-74 EcoPac™ 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-74 EcoPac™ always has the same excellent features.



Grytgöls Bruk AB

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Product information:

Dimension / Weight			Welding characteristics		
Dim. (mm)	W250 (kg)	F450 (kg)	Welding current	Arc voltage	Wire feeding
0,80	Ca 225		70-185 A	18-24 V	6-10 m/min
0,90	Ca 250	Ca 450	80-250 A	18-26 V	6-12 m/min
1,00	Ca 250	Ca 450	100-300 A	18-32 V	6-15 m/min
1,20	Ca 250	Ca 450	120-380 A	18-34 V	7-13 m/min
1,40		Ca 450	150-420 A	28-36 V	7-12 m/min
1,60		Ca 450	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

Approvals:

DNV GL
Deutsche Bahn
Lloyds Register of Shipping
TÜF

Welding current:

DC+

Classification:

SS-EN 14341 G3Si1

Shield gas:

CO2 25%, Ar 75%, 7-12 l/min.
CO2 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 CO₂ 25% and Ar 75% as shield gas.

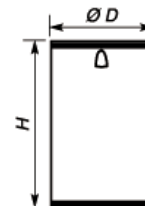
	Requirements SS-EN 14341 G3Si1	Typical values
Tensile strength (Mpa)	500-640	580
Yield strength (Mpa)	> 420	480
Elongation (%)	> 20	28
Impact value ft-ibs (J) at -20°C	> 47	108
Impact value ft-ibs (J) at -40°C		81



Packaging:

GB-74 EcoPac™ 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	ØD (mm)	H (mm)
W250 EcoPac™	4	520	830



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F450 EcoPac™	1	660	830
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