

# 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 550 lbs or 1000 lbs, 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. (inch)	W250 (lbs)	F450 (lbs)	Welding current	Arc voltage	Wire feeding
0.030	Aprox. 450		70-200 A	18-24 V	240-400 inch/min
0.035	Aprox. 550	Aprox. 900	80-250 A	18-26 V	240-475 inch/min
0.045	Aprox. 550	Aprox. 1000	120-380 A	18-34 V	275-510 inch/min
0.052		Aprox. 1000	150-420 A	18-36 V	275-475 inch/min
0.0625		Aprox. 1000	225-550 A	28-38 V	275-475 inch/min

**Wire composition:**

	C	Si	Mn
AWS A5.18 ER 70S-6 (%)	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:**

CO<sub>2</sub> 25%, Ar 75%, 1,85-3,20 gallon/min.

CO<sub>2</sub> 100%, 1,85-3,20 gallon/min.

**Quality:**

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

**Mechanical properties:**

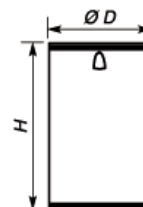
Values for fully welded test bars with CO<sub>2</sub> 25% and Ar 75% as shield gas.

	Requirements AWS A5.18 ER 70S-6	Typical values
Tensile strength PSI (Mpa)	72 500-93 000 (500-640)	84 000 (580)
Yield strength PSI (Mpa)	> 610 000 (> 420)	70 000 (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 (inch)	H (inch)
W250 EcoPac	4	20,5	32,7
F450 EcoPac	1	26,0	32,7



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