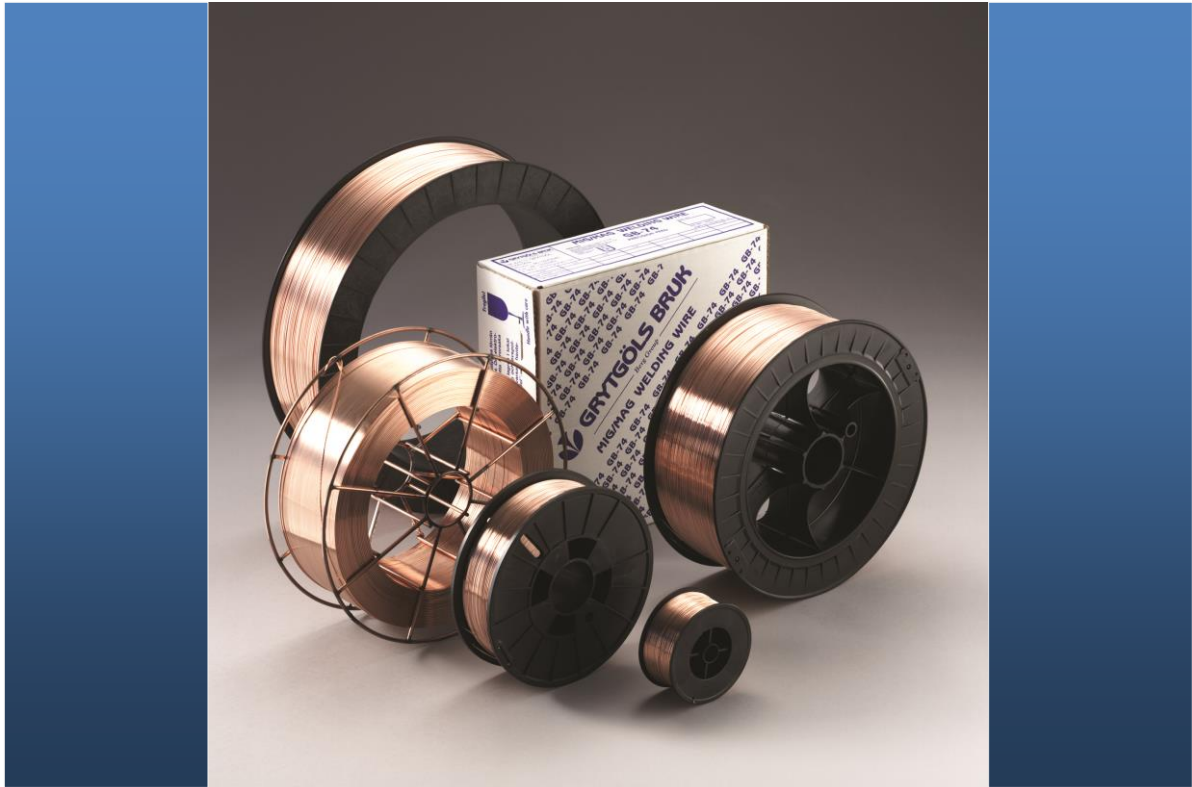


GB-74™

MIG/MAG welding wire on spool



GB-74™ is our best-selling welding wire. It is a silicon manganese alloy, copper coated welding wire, designed for MIG/MAG welding in non-alloy and low alloy steels and welded using pure CO₂ or a mixture of gases. With a mixture of gases, a higher welding-speed can be achieved and spatter is reduced in most cases, this justifies the slightly more expensive mixture.

The carefully controlled metallurgy of the wire guarantees welded joints with extraordinarily good strength and penetration properties.

The high-quality copper coating on the surface layer, tight dimensional tolerances and absolute purity ensure precise, reliable wire feed for both manual and automated welding.

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



Grytgöls Bruk AB

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Product information:

Dimension / Weight					Welding characteristics		
Dim (mm)	CO1 (kg)	CO5 (kg)	CO15 (kg)	CO18 (kg)	Welding current	Arc voltage	Wire feeding
0,60	1	5	15	18	50-100 A	15-20 V	8-13 m/min
0,80	1	5	15	18	70-185 A	18-24 V	6-10 m/min
0,90	1	5	15	18	80-250 A	18-26 V	6-12 m/min
1,00	1	5	15	18	100-300 A	18-32 V	6-15 m/min
1,20			15	18	120-380 A	18-34 V	7-13 m/min
1,40			15	18	150-420 A	28-36 V	7-12 m/min
1,60			15	18	225-550 A	28-38 V	7-12 m/min

 Not on stock

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:

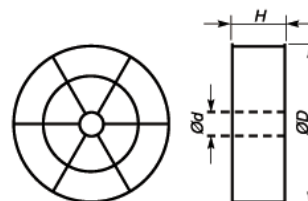
Values for fully welded test bars with CO₂ 25% and Ar 75% as shield gas.

	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™ on spools are supplied on plastic spools. The spools fit all automatic welding machines having a diameter of about 51 mm. For corrosion protection, all spools are packed into plastic bags and then put into cardboard boxes.

Packaging	Pcs/pallet	∅D (mm)	∅d (mm)	H (mm)
CO1	16/box	100	16,5	44
CO5	135	200	51,5	55
CO15	50	300	51,5	100
CO18	50	300	51,5	100



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