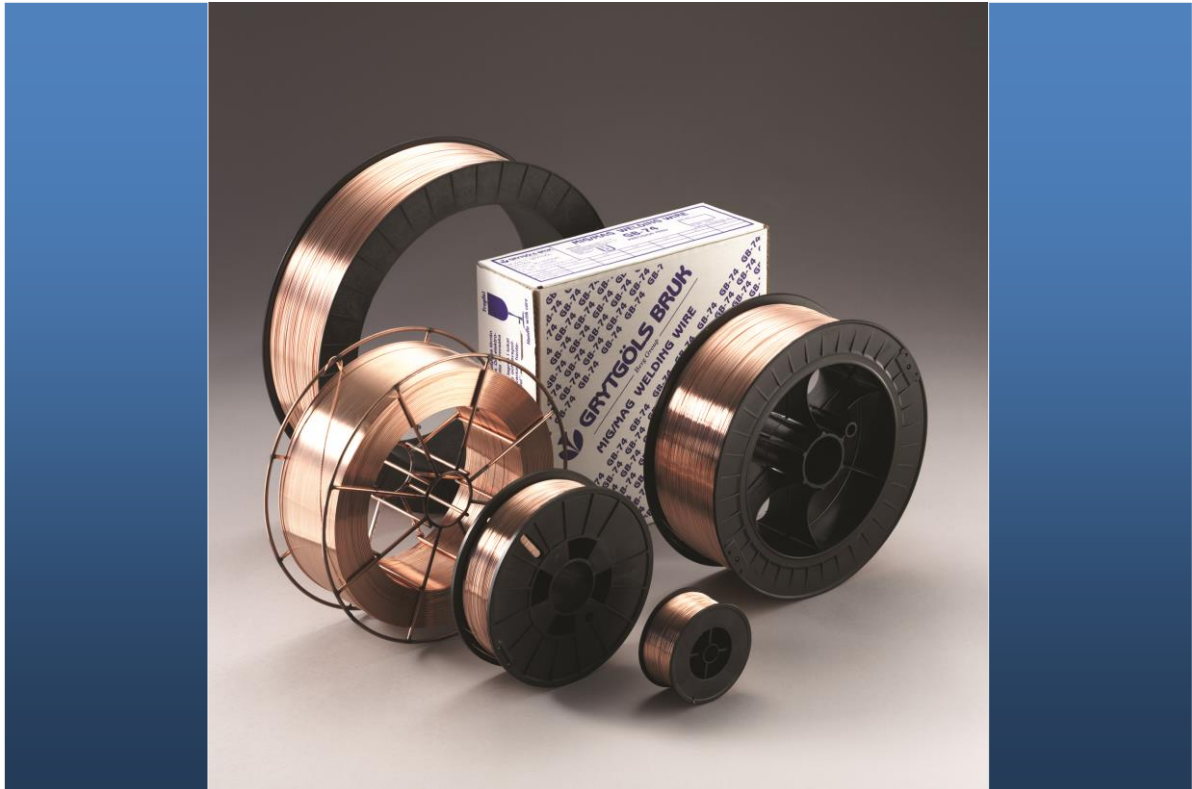


# GB-74™

## 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 CO<sub>2</sub> 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**

**SE-610 11 Grytgöl, Sweden**

**Phone: +46 122 622 60 • Fax: +46 122 433 63**

**E-Mail: [wire@grytgol.com](mailto:wire@grytgol.com) • Web page: [www.grytgol.com](http://www.grytgol.com)**

**Product information:**

Dimension / Weight						Welding characteristics		
Dim (inch)	2 spool (lbs)	11 spool (lbs)	33 spool (lbs)	45 spool (lbs)	60 coil (lbs)	Welding current	Arc voltage	Wire feeding
0.023	2	11	33			30-100 A	15-20 V	350-510 inch/min
0.030	2	11	33	45	60	70-200 A	18-24 V	240-400 inch/min
0.035	2	11	33	45	60	80-250 A	18-26 V	240-475 inch/min
0.045		11	33	45	60	120-380 A	18-34 V	275-510 inch/min
0.052				45	60	150-420 A	18-36 V	275-475 inch/min
0.0625				45	60	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:**

CO2 25%, Ar 75%, 1,85-3,20 gallon/min.

CO2 100%, 1,85-3,20 gallon/min.

**Quality:**

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

**Mechanical properties:**

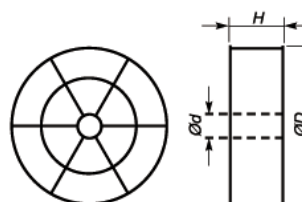
Values for fully welded test bars with CO<sub>2</sub> 25% and Ar 75% as shield gas.

	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™ on spools is 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	ØD (inch)	Ød (inch)	H (inch)
2 lbs plastic spool	1152	3,9	0,6	1,7
11 lbs plastic spool	216	7,98	2,0	2,2
33 lbs plastic spool	72	11,8	2,0	3,9
45 lbs plastic spool	60	11,8	2,0	3,9
60 lbs plastic coil	42	15,9	12,0	4,1



Berg Group  
**Grytgöls Bruk AB**

**SE-610 11 Grytgöl, Sweden**

**Phone: +46 122 622 60 • Fax: +46 122 433 63**

**E-Mail: [wire@grytgol.com](mailto:wire@grytgol.com) • Web page: [www.grytgol.com](http://www.grytgol.com)**