

# GB-76 EcoPac™

## MIG/MAG welding wire in drums



GB-76 EcoPac™ is a copper coated welding wire with increased silicon and manganese content, which contributes to better welding results in terms of higher degree of filling, less subsequent machining and higher tensile- and yield strength.

The drum is particularly suited to applications involving high consumption and requiring continuous operation, as in robotic welding and other mechanized applications, for example. The larger quantity of wire leads to markedly increased productivity, with a minimum of downtime for maintenance and wire changes, for example. It also offers the possibility of running unmanned shifts or production with reduced manning-levels.

The wire is placed in the drums by a special method, which allows it to be fed through the welding gun without rotating them. The straight wire guarantees more reliable starts and feed, together with 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-76 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-76 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 (%)	0,07	0,9	1,6

**Approvals:**

Deutsche Bahn  
TÜF

**Welding current:**

DC+

**Classification:**

SS-EN 14341 G4Si1

**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.

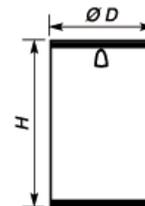


	Requirements AWS A5.18 ER 70S-6	Typical values
Tensile strength PSI (Mpa)	72 500-93 000 (500-640)	88 000 (610)
Yield strength PSI (Mpa)	> 610 000 (> 420)	74 000 (515)
Elongation (%)	> 20	29
Impact value ft-ibs (J) at -20°C	> 47	97
Impact value ft-ibs (J) at -40°C		83

**Packaging:**

GB-76 EcoPac™ 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 (inch)	H (inch)
W250 EcoPac™	4	20,5	32,7
F450 EcoPac™	1	26,0	32,7



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