

GB-76 RobotSpecial™ MIG/MAG welding wire in drums



For welding applications with high demands in terms of feeding and fast welding, and welds with the best possible penetration and filling degree, we have developed GB-76 RobotSpecial™, the ultimate welding wire.

GB-76 RobotSpecial™ is specially designed for robotic applications where emphasis is on precise positioning and rapid start-/stop sequences.

Packing welding wire in drums increase efficiencies along the entire weld chain in the form of effective management - reduced down time - reduced waste - increased process stability - improved weld quality, which lead to cost savings in the entire welding process.

GB-76 RobotSpecials™ unique characteristics have been developed in a new manufacturing process, which combines the latest manufacturing technology with our centuries-long experience in wire drawing in order to get a welding wire with extraordinary properties.

GB-76 Robot Special™ is a copper coated wire with increased silicon and manganese content, which contributes to the better welding results in higher filling rate, less post-processing and higher tensile and yield strength.

Produkt information:



Grytgöls Bruk AB

SE-610 11 Grytgöl, Sweden

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

E-Mail: wire@grytgol.com • Web page: www.grytgol.com

Dimension / Weight			Welding characteristics		
Dim. (mm)	F250 (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 G4Si1 (%)	0,06-0,14	0,8-1,2	1,6-1,9
Typical value (%)	0,07	0,9	1,65

Approvals:

Deutsche Bahn
TÜF

Welding current:

DC+

Classification:

SS-EN 14341 G4Si1

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:

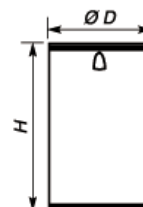
Values for fully welded test bars with CO₂ 25% and Ar 75% as shield gas.

	Requirements SS-EN 14341 G4Si1	Typical values
Tensile strength (Mpa)	500-640	610
Yield strength (Mpa)	> 420	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 RobotSpecial™ is delivered in drums made of environmental friendly cardboard. The special EcoPac 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)
F250 EcoPac™	4	520	830
F450 EcoPac™	1	660	830



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