

# 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.



**Grytgöls Bruk AB**

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**Produkt information:**

| Dimension / Weight |            |            | Welding characteristics |             |              |
|--------------------|------------|------------|-------------------------|-------------|--------------|
| Dim. (inch)        | F250 (lbs) | F450 (lbs) | Welding current         | Arc voltage | Wire feeding |
| 0.030              | Aprox. 450 |            | 70-200 A                | 18-24 V     | 240-400      |
| 0.035              | Aprox. 550 | Aprox. 900 | 80-250 A                | 18-26 V     | 240-475      |
| 0.045              | Aprox. 550 | Aprox.     | 120-380 A               | 18-34 V     | 275-510      |
| 0.052              |            | Aprox.     | 150-420 A               | 18-36 V     | 275-475      |
| 0.0625             |            | Aprox.     | 225-550 A               | 28-38 V     | 275-475      |

**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.

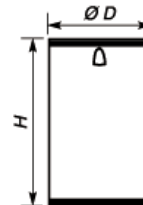


|                                  | Requirements AWS A5.18 ER 70S-6 | Typical values |
|----------------------------------|---------------------------------|----------------|
| Tensile strength PSI (Mpa)       | 72 500-93 000 (500-640)         | 88 000 (610)   |
| Yield strength PSI (Mpa)         | > 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 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 (inch) | H (inch) |
|--------------|------------|-----------|----------|
| F250 EcoPac™ | 4          | 20,5      | 32,7     |
| F450 EcoPac™ | 1          | 26,0      | 32,7     |



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