

GB-76™

MIG/MAG welding wire on spool



GB-76™ is a development of our popular GB-74™. The welding properties, which are already good, have been refined for special adaptation for applications having extremely stringent requirements for pore-free welds and good feed properties. GB-76™ is a coppered welding wire with an increased silicon and manganese content; this contributes to improved welding results in the form of higher degree of filling, less subsequent machining and a higher ultimate tensile strength and yield point.

With CO₂ as the protective gas, the increased silicon and manganese content leads to a higher calcination of silicon and manganese, which means that with GB-76™ and CO₂, the analysis of the weld deposit will be largely the same as with GB-74™ and a gas mixture. GB-76™ is characterized by a high-quality copper coating, close dimensional tolerances and absolute purity, which make for precise, reliable wire-feed for both manual and automated welding.

GB-76™ 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™ 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 • Web page: www.grytgol.com

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 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:

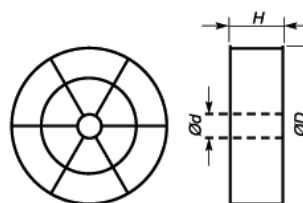
Values for fully welded test bars with CO₂ 25% and Ar 75% as shield gas.

	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™ 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 (mm)	Ød (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



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