

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 calcinations 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 (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 (%)	0,07	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:

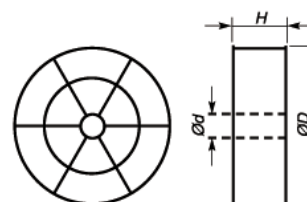
Values for fully welded test bars with CO₂ 25% and Ar 75% as shield gas.

	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™ 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	∅D (inch)	∅d (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



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