

## MG 30

**Standards** AWS/ASME SFA - 5.18 ER70S-6 EN ISO 14341 - A G 46 4 M21 4Si1 EN ISO 14341 - A G 46 4 C1 4Si1 TS EN ISO 14341 - A G 46 4 C1 4Si1 TS EN ISO 14341 - A G 46 4 M21 4Si1 DIN M. No. 1.5130

## **Properties and Applications**

Non-copper coated and unalloyed GMA (MIG/MAG) wire electrode, especially produced for welding without spatter or very low level of spatter. Suitable for welding of general structural steels, boiler steels, pipe steels and cast steels. Due to it's special coating provides stable arc and no spatter especially with mixed shielding gases which can be used depending on the thickness. Generally preferred in robotic applications due to it's high welding performance without spatter and cleaning needs. Also provides cost advantages in cleaning after welding, torch spare part consumptions like, contact tip, spiral, driving wheel, anti-spatter sprey. Due to these advantages preferably used in automotive, machine and steel furniture production.

Gas Metal Arc (MAG) Welding Wire - Non Alloyed Steels

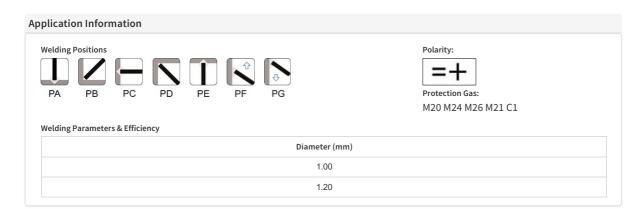
DIN GS-38, GS-45 StE 210.7 - StE 360.7 St 35.8 - St 45.8
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St 35.8 - St 45.8
HI, HII
St 37.4 - St 52.4
St 37.2 - St 52.3
17Mn4, 19Mn5
St 33 -St 52.0
A, B, D, E
StE 255 - StE 380

Typical Chemical Features of the Welding Wire						
Type of Analysis	С	Si	Mn			
Welding Wire	0.07	0.95	1.70			

## Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	C1	460	570	30	-40°C → 70
As welded	M21	480	580	27	-30°C → 95

<sup>\*</sup> Chemical compositon and mechanical properties are valid when using shielding gas



Packaging Information								
Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type		
21030DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)		
21030E1GM2	1.20	250 kg	257.50	1	257.50	Fiber Drum		
21030EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)		

## Storage & Re-Drying Information

Shouldn t be exposed to high statical load and impact. It should be stored in a dry room (relative humidity < 50%, room temperature >  $20^{\circ}$ C) on wooden pallets.