

MG 150

Gas Metal Arc (MAG) Welding Wire - High Strength and Low Alloyed Steels

Standards

| | |
|---------------------|-----------------|
| AWS/ASME SFA - 5.28 | ER80S-Ni1 |
| EN ISO 14341 - A | G 50 6 M21 3Ni1 |
| TS EN ISO 14341 - A | G 50 6 M21 3Ni1 |

Properties and Applications

Low alloyed wire electrode for GMA (MIG/MAG) welding of steels, which are subjected to operating temperatures down to -60°C. Weld metal has high strength and high toughness. Suitable to use in petrochemical, chemical, oil/gas industries and off-shore platforms, especially welding of pipes, boilers, tanks and valves, pumps which are made of cast or forged steels.

Materials

| Width | DIN | ASTM | API |
|-------------------|---------------------|----------------------|-----|
| 11MnNi5-3 | | | |
| 13MnNi6-3 | | | |
| S275NL - S460NL | TSIE 285 - TSIE 460 | | |
| S275ML - S460ML | | | |
| P275NL2 - P460NL2 | ESIE 285 - ESIE 460 | | |
| P355ML2 - P460ML2 | | | |
| | | A333 - A334 (Gr 1-6) | |
| | | A350 (Gr LF2-LF6) | |
| | | A352 (Gr LCB-LCC) | |
| L450MB | | | X65 |

Typical Chemical Features of the Welding Wire

| Type of Analysis | C | Si | Mn | Ni |
|------------------|------|------|------|------|
| Welding Wire | 0.09 | 0,50 | 1.05 | 0.90 |

Typical Mechanical Values of Weld Metal

| Test Condition | Protection Gas | Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Elongation A5 (%) | Charpy V-Notch Properties (J) |
|----------------|----------------|-------------------------------------|---------------------------------------|-------------------|-------------------------------|
| As welded | M21 | 480 | 570 | 28 | -60°C → 60 |

* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M21 (Ar + %15-25 CO₂).

Application Information

Welding Positions

PA PB PC PD PE PF PG

Polarity:

Protection Gas:
M21

Welding Parameters & Efficiency

| Diameter (mm) |
|---------------|
| 0.80 |
| 1.00 |
| 1.20 |

Packaging Information

| Product Code | Diameter (mm) | Quantity per Box | Box Gross Weight (kg) | Boxes per Outer Box | Outer Box Gross Weight (kg) | Packaging Type |
|--------------|---------------|------------------|-----------------------|---------------------|-----------------------------|----------------------------|
| 22010BJAM2 | 0.80 | 15 kg | 15.70 | 1 | 15.70 | Wire Basket Spool (K300MS) |
| 22010DJAM2 | 1.00 | 15 kg | 15.70 | 1 | 15.70 | Wire Basket Spool (K300MS) |
| 22010EJAM2 | 1.20 | 15 kg | 15.70 | 1 | 15.70 | Wire Basket Spool (K300MS) |

Storage & Re-Drying Information

Shouldn't be exposed to high static load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.