

MG 150W

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

Standards	
AWS/ASME SFA - 5.28	ER80S-G
EN ISO 14341 - A	G 42 2 M21 Z2NiCu
TS EN ISO 14341 - A	G 42 2 M21 Z2NiCu

Properties and Applications

Low-alloyed GMA (MIG/MAG) welding wire designed for welding of weathering steels (like COR-TEN) with high mechanical properties. Due to nickel and copper alloys, it provides higher corrosion resistance than carbon steels. Suitable for welding in steel construction manufacturing such as bridge, stadium and steel construction.

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	Cu
Welding Wire	0.09	0.80	1.40	0.80	0.40

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	470	600	27	-20°C → 47

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

Application Information

Welding Positions

Polarity:

Protection Gas:
M21

Welding Parameters & Efficiency

Diameter (mm)
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
22012DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22012EJAM2	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.