

MG 182

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

Standards

AWS/ASME SFA - 5.28	ER110S-G
EN ISO 16834 - A	G 69 6 M21 Mn4Ni1,5CrMo
TS EN ISO 16834 - A	G 69 6 M21 Mn4Ni1,5CrMo

Properties and Applications

Low alloyed wire electrode for GMA (MIG/MAG) welding of fine grained and high strength steels with yield strength of up to 690 N/mm². Weld metal exhibits good toughness properties down to -60°C. Especially used in high strength pipe-lines, earthmoving and mining equipments, trucks, mobile cranes, concrete pumps cranes and lift productions.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	Mo	Ti
Welding Wire	0.09	0.55	1.55	0.25	1.35	0.25	0.07

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	750	820	20	-60°C → 55

* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M21 (%82 Ar + %18 CO₂).

Application Information

Welding Positions

PA PB PC PD PE PF PG

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
22022DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22022EJAM2	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.