

MG 201A

Gas Metal Arc (MAG) Welding Wire - Creep Resisting Steels

Standards	
AWS/ASME SFA - 5.28	ER80S-D2
EN ISO 21952 - A	G Z MnMo
TS EN ISO 21952 - A	G Z MnMo

Properties and Applications

Low alloyed wire electrode for GMA (MIG/MAG) welding of creep resistant boiler and pipe steels subjected to operating temperatures up to 530°C. Contains high level of deoxidizing (Mn and Si) elements to control porosity during welding. Welds are of X-ray quality. Also suitable for joining C-Mn steels to be postweld heat treated. Observe directions as to pre and post weld heat treatment of base material. CO₂ or mixed shielding gases can be used depending on the thickness of the base metal. A thin and homogeneous copper coating increases electrical conductivity and protects the wire from rusting.

Materials	
Width	DIN
S255N - S460N	StE 255 - StE 460
P235G1TH - P255G1TH	St 35.8 - St 45.8
P235GH, P265GH	H I, H II
P295GH, P355GH	17Mn4, 19Mn5
16Mo3	15Mo3
L360NB - L415NB	StE 360.7 - StE 415.7
L450MB, L485MB	StE 445.7 TM, StE 480.7 TM
	X52 - X70

Typical Chemical Features of the Welding Wire				
Type of Analysis	C	Si	Mn	Mo
Welding Wire	0.09	0.75	1.90	0.45

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	520	600	22	0°C → 60	-20°C → 50

* 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:
M20 M21 C1

Welding Parameters & Efficiency

Diameter (mm)
0.80
1.00
1.20
1.60

Packaging Information						
Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
22001BJAM2	0.80	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22001D1GM2	1.00	250 kg	261.00	1	261.00	Fiber Drum
22001DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22001E1GM2	1.20	250 kg	261.00	1	261.00	Fiber Drum
22001EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22001GJAM2	1.60	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°C) on wooden pallets.