

MG 211

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

Standards

AWS/ASME SFA - 5.28	ER80S-G
EN ISO 21952 - A	G CrMo1Si
TS EN ISO 21952 - A	G CrMo1Si
DIN M. No.	1.7339

Properties and Applications

Low-alloy wire electrode for GMA (MIG/MAG) welding of Cr-Mo alloyed creep resistant boiler and pipe steels subjected to operating temperatures up to 570°C. 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.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Mo
Welding Wire	0.09	0.60	1.00	1.20	0.50

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	630	750	18	20°C → 80
Isil İşlem Sonrası (685°C 1 Saat)	M21	500	600	28	20°C → 120

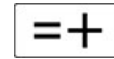
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M21 (%82 Ar + %18 CO₂).

Application Information

Welding Positions



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
22002BJAM2	0.80	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22002DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22002DMAM2	1.00	15 kg	15.20	1	15.20	Wire Basket Spool (K300)
22002EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
22002GJAM2	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.