

**SGQ
SIAT S.p.A.**

1. DESCRIPTION

Gas shielded welding wire in according to the standards UNI EN ISO 14341-A-G 2Si and AWS A5.18 ER70S-3 suitable to join common steels for construction. Available in copper coated wire and no-copper wire.

2. PRODUCT CHEMICAL COMPOSITION (%)

		C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	V	Ti+Zr
PITTARC G3	Min	0.06	0.90	0.50	-	-	-	-	-	-	-	-	-
	Max	0.14	1.30	0.75	0.025	0.025	0.15	0.15	0.15	0.30	0.02	0.03	0.15
EN ISO 14341-A-G 2Si	Min	0.06	0.90	0.50	-	-	-	-	-	-	-	-	-
	Max	0.14	1.30	0.80	0.025	0.025	0.15	0.15	0.15	0.35	0.02	0.03	0.15
AWS A5.18 ER70S-3	Min	0.06	0.90	0.45	-	-	-	-	-	-	-	-	-
	Max	0.15	1.40	0.75	0.025	0.035	0.15	0.15	0.15	0.50	-	0.03	-

3. WIRE DIMENSIONS

Standard diameter (mm): 0.8; 1.0; 1.2; 1.4; 1.6
Permissible deviations: ISO 544

4. CAST AND HELIX (STANDARD PACKAGING)

Cast (mm): 800 ÷ 1000
Helix (mm): maximum 10

5. ALL-WELD-METAL MECHANICAL PROPERTIES

	Re MPa	Rm MPa	A5 %	KV (-20°C) J
AWS A5.18 ER70S-3	≥ 400	≥ 480	≥ 22	≥ 27
EN ISO 14341-A G38 2 M21 2Si	≥ 380	≥ 470	≥ 20	≥ 47
PITTARC G3	≥ 400	≥ 480	≥ 22	≥ 47

Gas protection: ISO 14175 M21 mixture (80% Ar + 20% CO₂).

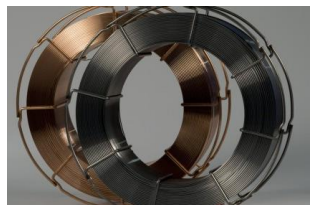
Classification: ISO 14341-A-G 38 2 M21 2Si

6. STANDARD PACKAGING



Wire basket rim RG (ISO 544 B300) of 18 kg net weight. Each spool sealed in a polyethylene airtight bag and packed into a cardboard box. 72 spools stacked onto a pallet secured by thermoplastic shrink-wrapping (94x125x80 cm, 1296kg net weight). Available cardboard drums of about 250kg net weight, each one stacked onto a pallet 105x105x90 cm of about 1000kg total weight, secured by thermoplastic shrink-wrapping. On request packaging available from 15 kg up to 700 kg.

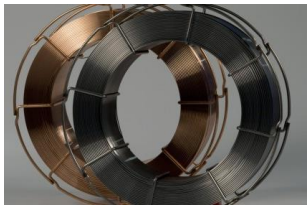
7. STANDARD IDENTIFICATION

A label is attached to the inside of each spool containing nominal diameter, trade name, classification, heat number, operator code. A label is attached to every box containing manufacturer, trade name, nominal diameter, heat number, spool type, references to the standards, CE mark and approvals.



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 PITTARC	SIAT S.p.A. 33013 Gemona del Friuli (UD) ITALY			
<p>8</p>  0036 06 ref. DoP PITTARC G3-2020-10 EN 13479:2017	<h2>PITTARC G3</h2>			
Use in metallic structures or in composite metal and concrete structures	Welding wire for carbon steels and fine-grained steels EN ISO 14341-A-G 38 2 M21 2Si and AWS AWS A5.18 ER70S-3 Shielding gas according to ISO 14175 C1-M21 Current/Polarity G			
	Weight kg XX	Heat N° XXXXX/XX	Diameter X,X mm	Spool type X XXX



8. STANDARD CERTIFICATION

Documents according to EN 10204.

9. APPROVALS

None.