



HILCO FER G1

Gas welding rods – unalloyed steel

EN 12536: O I
AWS A5.2: ~ R 45

Wire type:
OAW Solid wire

Shielding gas:
Oxy-acetylene

Welding positions:



Fer G1 is our copper coated rod for oxy-acetylene gas welding of unalloyed structural steels. Fer G1 is easy flowing and gives a very clean smooth weld. Operating temperature of the workpiece is maximum 350°C.

Base materials to be welded:

- Structural steel S185-255, St.33-St37.3
- Boiler steel P235GH-P265GH, HI, HII
- Pipe steel P235T1-L210, St.37.0-St.44.0

Applications:

- General fabrication & construction
- Repair & Maintenance

Chemical composition, wt.% weld metal – typical:

C	Mn	Si
0,08	0,50	0,10

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 260	≥ 360	≥ 20	20°C ≥ 30

Note: properties under oxy-acetylene gas

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
1,6	1000	5 / 25
2,0	1000	5 / 25
2,4	1000	5 / 25
3,0	1000	5 / 25
4,0	1000	5 / 25