

ENERGOMAG 2-CF



Solid wire, copper free

Classifications	DIN 8559	EN ISO 14341-A	AWS A 5.18
	SG2	G42 4 C1/M21 3 Si1	ER 70S-6

Description Copper free solid wire for welding unalloyed and low alloy steels with CO₂ or gas mixture. Promotes a low sensitivity to surface impurities and contributes to smooth welding. Reduced contact tip wear is observed as well as improved protection against corrosion. Used in general construction, shipbuilding and automotive components. Especially dedicated to mechanised welding processes. Provides stable arc, low level of spatter and low fume emission.

Base materials Steels with a yield strength ≥ 420 MPa
S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S420N, S275M-S420M, P235GH-P355GH, P275NL1-P355NL1, P215NL, P265NL, P355N, P285NH-P420NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L245MB-L415MB, GE200-GE240, ship building steels: A, B, D, E, A 32-E 36

Typical composition of solid wire (%)	C	Si	Mn	S	P	Cu
	0,06-0,14	0,7-1,0	1,3-1,6	$\leq 0,025$	$\leq 0,025$	$\leq 0,35$

Mechanical properties of all-weld metal (acc. to EN 15792-1, shielding gas M21)	Yield strength 0,2% N/mm ²	Tensile strength N/mm ²	Elongation (L ₀ = 5d ₀) %	Impact values in J CVN -40 ° C
	≥ 420	500-640	≥ 20	≥ 47

Welding positions



Polarity =+

Shielding gases: (EN ISO 14175: M2, M3, C)

Dimensions (mm) 0,6-1,6

Spool /packing 15kg spools BS300 / 250kg drum

Certificates CE, TÜV, DB

