



Elgomatic 103

GMAW - MIG MAG
Un-alloyed

Date: 2012-09-28
Revision: 11

Description:

Rev. 10 still valid.

Elgomatic 103 is a copper coated, manganese-silicon double deoxidised wire of the SG3 type, for use with a CO₂ or Ar/CO₂ gas shield. The increased Mn content produces a higher weld metal strength level and better notch toughness compared to SG2 type wire. Elgomatic 103 is suitable for all general engineering and structural steels.

Welding current:

DC+

Wire composition, wt.%

	C	Si	Mn	P	S	Cu
Min	0,06	0,8	1,6			
Typical	0,09	0,9	1,7	0,015	0,010	0,05
Max	0,13	1,2	1,9	0,025	0,025	0,30

Shielding gas:

100% CO₂, 7-12 l/min

80% Ar + 20% CO₂, 7-12 l/min

Chemical composition, wt.%

	C	Si	Mn
Min			
Typical	0,07	0,8	1,6
Max			

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 460 MPa	510 MPa
Tensile Strength, Rm:	≥ 530 MPa	610 MPa
Elongation, A5	≥ 22%	24%
Impact energy, CV:	-20°C • 47 J	-20°C • 90 J -40°C • 60 J

Classification:

EN ISO 14341-A
AWS A5.18

G 46 2 (C) M G4Si1
ER70S-6

Approvals:

TÜV
CE

Note

Also available in AUTOPAC, a twist-free pay-off pack. For more information about Part no, type of spool and winding, please study the price list.

Product data:

Diam.mm	Product code	Spool weight	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
0,8	Contact Elga/ITW	Contact Elga/ITW	50-90	16-18	120-160	22-26
1,0	Contact Elga/ITW	Contact Elga/ITW	80-150	17-20	180-230	24-30
1,2	Contact Elga/ITW	Contact Elga/ITW	110-180	18-22	240-300	26-33
1,6	Contact Elga/ITW	Contact Elga/ITW	110-180	18-22	240-300	26-33