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### 1. DESCRIPTION

Gas shielded welding wire conforming to the standard UNI EN ISO 16834-A- G 69 4 M21 Mn3Ni1CrMo and AWS A5.28 ER110S-G suitable to join high strength and Cr-Ni-Mo low alloy steels. 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   |
|----------------------------------|-----|------|------|------|-------|-------|------|------|------|------|------|------|------|
| PITTARC<br>GTA                   | Min | 0.08 | 1.60 | 0.50 | -     | -     | 0.30 | 1.40 | 0.24 | -    | -    | 0.08 | -    |
|                                  | Max | 0.11 | 1.80 | 0.70 | 0.015 | 0.018 | 0.40 | 1.60 | 0.30 | 0.35 | 0.12 | 0.13 | 0.10 |
| EN ISO<br>16834-A-<br>Mn3Ni1CrMo | Min | -    | 1.30 | 0.40 | -     | -     | 0.20 | 1.20 | 0.20 | -    | -    | 0.05 | -    |
|                                  | Max | 0.12 | 1.80 | 0.70 | 0.015 | 0.018 | 0.40 | 1.60 | 0.30 | 0.35 | 0.12 | 0.13 | 0.10 |

### 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 (-40°C)<br>J |
|--|---------|-----------|--------|-----------------|
| AWS A5.28 ER110S-G                       | (≥ 660) | ≥ 760     | (≥ 15) | -               |
| EN ISO 16834-A- G 69 4<br>M21 Mn3Ni1CrMo | ≥ 690   | 770 ÷ 940 | ≥ 17   | ≥ 47            |
| PITTARC GTA                              | ≥ 690   | ≥ 770     | ≥ 17   | ≥ 47            |

Gas protection : ISO 14175 M21 mixture . Preheating and interpass temperature: 120 ÷ 180 °C  
Recommended welding parameters (diam. 1,2 mm): 250÷300A; 25÷30V; wire feed speed ~5m/min; travel speed ~6mm/sec; tip to work ~20mm.

### 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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TECHNICAL SPECIFICATION  
GMAW WELDING WIRE  
PITTARC GTA

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18.09.2014  
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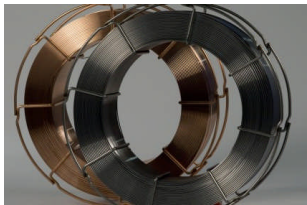
|  | SIAT S.p.A.<br>33013 Gemona del Friuli (UD) ITALY  |           |            |          |            |    |          |        |       |
|---|--|-----------|------------|----------|------------|----|----------|--------|-------|
|  | <h2>PITTARC GTA</h2>   |           |            |          |            |    |          |        |       |
| 0036 06<br>ref. DoP<br>PITTARC GTA-2014-04<br>EN 13479:2004                       | Welding wire for high strength steels<br>EN ISO 16834-A – G 69 4 M21 Mn3Ni1CrMo and AWS A5.28 ER110S-G<br><br>Shielding gas according to ISO 14175 M21<br>Current/Polarity G+, Welding positions: PA, PB, PC, PF   |           |            |          |            |    |          |        |       |
| Use in metallic structures or in composite metal and concrete structures          | APPROVALS : TUV Nr.10886<br><br><table border="1"> <thead> <tr> <th>Weight kg</th> <th>Heat N°</th> <th>Diameter</th> <th>Spool type</th> </tr> </thead> <tbody> <tr> <td>XX</td> <td>XXXXX/XX</td> <td>X,X mm</td> <td>X XXX</td> </tr> </tbody> </table> | Weight kg | Heat N°    | Diameter | Spool type | XX | XXXXX/XX | X,X mm | X XXX |
| Weight kg   | Heat N°  | Diameter  | Spool type |          |            |    |          |        |       |
| XX  | XXXXX/XX   | X,X mm    | X XXX      |          |            |    |          |        |       |

### 8. STANDARD CERTIFICATION.

Documents according to EN 10204

### 9. APPROVALS

TÜV



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