



MIG F55

Old reference: MIG GALVARC

Classification

AWS A5.18 : ER70S-2

ISO 14341-A : G 42 2 M21 2Ti

ISO 14341-A : G 38 2 C1 2Ti

Description & Applications

Copper coated solid wire for gas (Ar + CO₂ or 100% CO₂) metal arc welding of low alloyed standard construction / boiler steels like E24 (S235-S355; P235-P310). Could be used on galvanised plate.

Main applications: General construction, pressure vessel...

Base material:

Construction steels for general use:

EN	ASTM
S275 – S355	A106 grade A, B, C
P275 – P355	A131 grade A, B, D
L210 – L360	A139

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti	Zr	V	P	S	Ti+Zr
Min	0.04	0.4	0.9					0.05	0.05	0.05				0.05
Max	0.07	0.7	1.40	0.15	0.15	0.15	0.35	0.20	0.15	0.12	0.03	0.025	0.025	0.25
Type	0.06	0.60	1.2	0.06	0.02	0.01	0.20	0.10	0.10	0.08	0.01	0.015	0.010	0.18

All Weld Metal Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	420	500	22	-20°C >47 -30°C >27
Max		640		
Type	520	570	28	-20°C 120 -30°C 85

* Shielding gas: M21 (Ar + CO₂)

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	60 - 200	16 - 28	ISO 14175: M21 (Ar/CO ₂) C1 (100% CO ₂) 12-15 l/min
	1.0	80 - 260	17 - 32	
	1.2	100 - 360	18 - 34	

FT En-MA01-191113

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