

**Wire type:**  
OAW Solid wire

**Shielding gas:**  
Oxy-acetylene

**Welding positions:**



Fer G 1 is our copper coated rod for oxy-acetylene gas welding of unalloyed structural steels. Fer G 1 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