

Gold G4Si1

Marking according to standards: EN ISO 14341-A: G 42 4 C1 4Si1,
EN ISO 14341-A: G 46 4 M21 4Si1,
SFA / AWS A5.18: ER 70 S-6

Manganese-silicon, copper Electrode Wire for MIG/MAG welding of low carbon and unalloyed steel

General description:

GOLD G4Si1 copper Electrode Wire for MIG/MAG welding in all positions. Shielding gas: CO₂ or Ar+ CO₂. Wire includes more Si and Mn when compared to GOLD G3Si1 wire which provides a higher tensile strength and resistance to contamination of welded elements.

Welding positions:



Current type:

DC+

Gas flow:

14 – 20 l/min

Welded metal typical chemical composition

C	Si	Mn	P	S
0.10	1.00	1.70	0.010	0.010

Welded material

P235/ S 235 to P 460/ S 460 and other steel types

Typical mechanical properties

Limit of yield [N/mm ²]	Limit of strength [N/mm ²]	Elongation [%]	Impact strength [J] -40°C
475	570	30	70

Recommended welding parameters (DC+)

Diameter of wire [mm]	Welding current [A]	Arc voltage [V]	Gas flow [l/min]	Wire feeding [m/min]	Metal yield [kg/h]
0,80 mm	60 - 185	18 - 24	14	3,2 - 10	0,8 - 2,5
1,00 mm	80 - 300	18 - 32	16	2,7 - 15	1,0 - 5,5
1,20 mm	120 - 380	18 - 35	18	2,3 - 15	1,2 - 8,0
1,60 mm	120 - 380	18 - 35	20	2,3 - 15	1,2 - 8,0

Approvals:

TUV (11189.06), DB (42.078.02), RMRS

Packaging method:

0.8-1.6 mm: 15 kg & 5 kg spools