

STANDARD HOT DIPPED GALVANIZED WIRE

RELATED SPECIFICATIONS:

Australia	AS 4534 W02Z
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DESCRIPTION:

The metallic zinc coatings applied by the galvanising process are an effective way of combating corrosion in steel. Standard galvanised coatings are smoother, however less corrosion resistant than heavy galvanised coatings. Our standard hot dipped galvanized wire comes in a soft grade wire.

APPLICATIONS:

Include cages, bucket handles, coat hangers and baskets.

CHEMICAL ANALYSIS:

	C %	Si %	Mn %	P %	S %
Min.	-	0.12	-	-	-
Max.	0.05	0.18	0.05	0.03	0.03

TYPICAL MECHANICAL PROPERTIES:

Size (mm)	U.T.S (MPa)	Zinc Coating
>2.24-3.15	380-550	>45g/m ²
>3.15-3.55	380-550	>50g/m ²
>3.55-4.25	380-550	>60g/m ²
>4.25-5.00	380-550	>70g/m ²
>5.00-6.30	380-550	>80g/m ²

PACKAGING:

Coils

Metal strapped and gunny wrapped.

Straightened Lengths

Slightly oiled wire surface. 20x25kg bundles, metal strapped and gunny wrapped

SIZES AVAILABLE:

Coils

Wire Size	Coil Size
2.24 – 3.15mm	500kg
3.15 – 3.55mm	500kg

Straightened Lengths

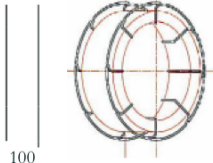
Wire Size
2.24 – 3.15mm
3.15 – 3.55mm
3.55 – 4.25mm
4.25 – 5.00mm
5.00 – 6.30mm

Note: welded joints in the compressed coils.

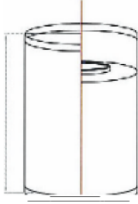
Straightened lengths can be supplied 800mm to 2200mm cut lengths

		C %	Mn %0	Si %	Ni %10	Cr %A,	Mo %	Cu %	Ti %	B %	N %
PITTARC S1	EN 756 - S1 AWS A5.17 EL12	0,08	0,50	0,10							
PITTARC S2	EN 756 - S2 AWS A5.17 EM12K	0,09	1,00	0,12							
PITTARC S3	EN 756 - S3 AWS A5.17 EH10K	0,10	1,50	0,10							
PITTARC S4	EN 756 - S4 AWS A5.17 EH14	0,12	1,80	0,08							
PITTARC S2Si	EN 756 - S2S1 AWS A5.17 EM12K	0,09	1,00	0,25							
PITTARC S3Si	EN 756-S3S1 AWS A5.17 EH12K	0,10	1,75	0,25							
PITTARC S2Mo	EN 756- S2Mo AWS A5.23 EA2	0,10	1,10	0,10							
PITTARC S3Mo	EN 756 - S3Mo AWS A5.23 EA4	0,12	1,50	0,10							
PITTARC S4Mo	EN 756 - S4Mo AWS A5.23 EA3	0,12	1,80	0,13							
PITTARC SH2	EN 756 - S0 AWS A5.23 EG	0,10	1,00	0,20	0,70	0,17		0,50			
PITTARC S2Ni2Mo	EN 756 S0 - AWS A5.23 EG	0,07	1,20	0,12	2,10		0,50				
PITTARC S3MoTiB	EN 756 - S0 AWS A5.23 EG	0,08	1,30	0,25			0,50		0,15	0,013	0,005 max


SUBMERGED ARC WELDING WIRES



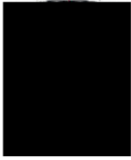
LA-LB-LC 20-25-27 kg



TC 350 kg
TF*450/550 kg $\varnothing \leq 2,0$
TI**400/700 kg $\varnothing \leq 2,0$



GF 900 kg



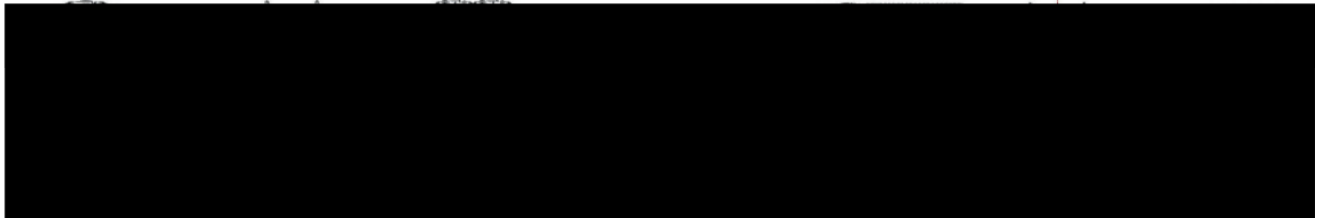
HM 900 kg

SUBMERGED ARC WELDING FLUXES

PITTARC FL 160F	EN 760: S A FB 1 55 AC H5 EN 756: S 46 6 FB S3Si / S 46 5 FB S4 EN 756: S 50 4 FB S4Mo AWS A5.17: F7AP8-EH12K / F7AP6 EH14 AWS A5.23:F7AP6-EA3-A3	Agglomerated basic flux suitable for welding of carbon steel and low alloy steels with good impact values at low temperature.
PITTARC FL	EN 760: S A AR 1 87 AC EN 756: S 4T A AR S1 / S 4T 0 AR S2 EN 756: S 4T 0 AR 5231/ S 4T 0 AR S0 AWS A5.17: F7A0-EL12 / F7A0-EM12 AWS A5.17: F7A0-EM12K / F7A0-EH14 AWS A5.23: F7AZ-EG-G (SH2)	Agglomerated rutile flux additive in manganese and silicon, suitable for carbon steel welding with two or three passes.
PITTARC FL	EN 760: S A AB 1 67 AC H5 EN 756: S 35 2 AB Si / S 42 3 AB S2 AWS A5.17: F7AP4-EM12K AWS A5.17: F6AP2-EL12 / F7AP4-EM12 AWS A5.23: F8AP2-FA2-A2 / F7AP2-EG-G	Agglomerated semi-basic flux suitable for carbon alloy steel welding in single and multipass technique and in single or multi-wire applications.

		C %	Mn %	Si %					Rm N/mm ²	Re N/mm ²	A5d %	KV J
PITTARC G3	EN 440 - G38 2M G2Si AWS A.5.18 ER70S-3	0,08	1,20	0,60					530	430	26	-20°C 90 J
PITTARC G6	EN 440 - G42 4M G3Si1 AWS A.5 18 ER70S-6	0,08	1,50	0,85					580	480	26	-40°C 60 J
PITTARC G9	EN 440 - G46 4M G4Si1 AWS A.5 18 ER70S-6	0,08	1,75	0,95					600	500	26	-40°C 60 J

		C %	Mn %	Si %	Ni %	Cr %	Mo %	Cu %	Rm N/mm ²	Re N/mm ²	A5d %	KV J
PITTARC GH2	EN 12534-Z AWS A.5 28 ER80S-G	0,08	1,40	0,80	0,75	0,30		0,40	650	600	25	-20°C 90 J
PITTARC GTH	EN 12534-G62 4M Mn3NiCrMo AWS A.5 28 ER100S-G	0,09	1,70	0,70	0,55	0,55	0,25		750	650	21	-40°C 70 J
PITTARC GTA	EN 12534-069 4M Mn3Ni1CrMo AWS A.5 28 ER110S-G	0,09	1,70	0,60	1,45	0,35	0,25		820	720	20	-40°C 70 J



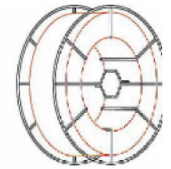
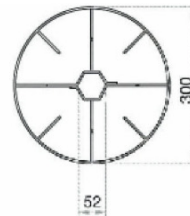
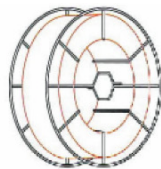
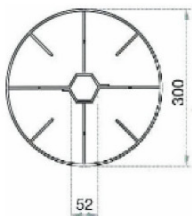
180
300

98

103

RF•RG 16-18 kg

RC•RD 15 kg PLW 15 kg SRW



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