

Weld G-105

Gas Metal Arc Welding Wire



PRODUCT DESCRIPTION

Weld G-105 deposit is a low alloy steel developed for the rebuilding of carbon and low alloy steel parts used in applications involving metal-to-metal wear. G-105 requires carbide tools for machining. It is good for hot wear applications up to 315°C. Multiple layers can be applied without difficulty when proper preheat and interpass temperatures are maintained.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Moderate
Impact Resistance	Moderate
Hardness on 0.2 Carbon Steel, HRC	41-46
Deposit Layers	Multiple
Magnetic:	
On Low Alloy and Carbon Steel	Yes
On Manganese Steel	No
Surface Cross Checks	No

ALLOY TYPE(Typical value%)

Low Alloy Steel

C	Si	Mn	Cr	Mo	Other	Fe
0.25	1.2	1.8	2.8	0.5	≤ 0.5	Bal

STANDARDS & EQUIVALENCE

EN 14700 :	T Fe1
DIN 8555 :	MF 1-45-GT

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS (DCEP)

Diameter, (mm)	1.6
Current DCEP, amp	200 - 300
Voltage (volts)	22 - 31
Wire Extension, (mm)	12 - 25
Shielding Gas	75%Ar+25%CO ₂
Position	Flat or Horizontal

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part No
1.6 mm	12.5kg/ Plastic Spool	EWG10516E

TYPICAL APPLICATIONS

- Tractor Rollers
- Undercarriage parts
- Shovel Idlers and Rollers
- Shovel House Rolls (Hook Rolls)
- Top Carrier Rolls
- Crane Wheels
- Mine Car Wheels



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