



# Elgamatic 140

GMAW - MIG MAG

Low-alloyed

Date: 2008-01-22  
Revision: 9

## Description:

Elgamatic 140 is a copper coated wire for use with the MIG/MAG process, which deposits a 0.8% Ni / 0.4% Cu weld metal having improved corrosion resistance to that of mild steel when exposed to environments containing salt and sulphurous gases. It is primarily intended for welding weather resisting steels such as Cor-Ten, but is also suitable for higher tensile, low temperature use steels.

## Welding current:

DC+

## Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min	0,06	0,7	1,25				0,7
Typical	0,09	0,7	1,4	0,01	0,01	0,22	0,8
Max	0,11	0,9	1,55	0,025	0,025	0,30	0,9

	Cu	V
Min	0,30	
Typical	0,3	0,004
Max	0,50	0,020

## Shielding gas:

C1, 100% CO<sub>2</sub>, 7-12 l/min.

M21, 80% Ar + 20% CO<sub>2</sub>, 7-12 l/min.

## Chemical composition, wt.%

	C	Si	Mn	P	S	Ni	Cu
Min							
Typical	0,09	0,5	1,15	0,01	0,01	0,75	0,36
Max							

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 470 MPa	560 MPa
Tensile Strength, Rm:	≥ 550 MPa	620 MPa
Elongation, A5	≥ 19%	25%
Impact energy, CV:		-20°C • 60 J

## Classification:

AWS A5.28

ER80S-G

## Approvals:

CE

## Note

Typical values are based on M21.

## Product data

Diam.mm	Product code	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
0,8	9528-2008	50-90	16-18	120-160	22-26
1,0	9528-2010	80-150	17-20	180-230	24-30
1,2	9528-2012	110-180	18-22	240-300	26-33