



DATA SHEET
DS 117
Rev. 3 dd 18/05/2015
INEGAS G1

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CLASSIFICATION

APPROVALS

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.2: R45	EN 12536: O I
AWS A 5.2M: RM30	
ASME SFA 5.2: R45	
ASME SFA 5.2M: RM30	

ALLOY TYPE

Copper-coated steel rod for oxy-acetylene welding of carbon and C – Mn steels of medium mechanical properties.

APPLICATIONS

Special copper-coated steel rod designed for oxy-acetylene (autogenous) welding of iron and carbon or carbon-manganese steels of medium mechanical properties. Suitable for pipes, tanks and structural works.

MATERIALS TO BE WELDED

ASTM		EN		Others
A131 Gr A, B, D		10025 Gr S185	10113-3 S275	
API 5LX		10025 Gr S235		
		10025 Gr S275		
		10028-2 P235		
		10028-2 P265		
		10028-2 P295		
		10113-2 S275		

WELDING GUIDELINES

Preheat and PWHT are not required.

TECHNICAL INFORMATION

Gas:

Welding position: all positions



WELDING PARAMETERS

Current	-
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PACKAGING DATA

Diameter (mm)	1.2	1.6	2.0	2.4	3.2	4.0
Length (mm)	1000	1000	1000	1000	1000	1000
Carton	5/25 Kg	5/25 Kg	5/25 Kg	5/25 Kg	5/25 Kg	5/25 Kg

* tolerances according to EN ISO 544 specification.



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TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Mo %	
0.07	0.50	0.07	0.012	0.012	0.15	-	-	-	

TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	-20	-30°C	-40°C	-50°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
-	as welded	-	500	-	-	-	-	-	-

PRODUCTS AVAILABLE

Process	Product	Classification AWS	Classification EN
Autogenous Welding			
SMAW Electrodes	INE 40	AWS A 5.1: E6013	EN 2560-A: E 42 0 RC
	INE 44	AWS A 5.1: E6013	EN 2560-A: E 42 0 RC
	INE 45	AWS A 5.1: E6013	EN 2560-A: E 42 0 R
	INE SUPER	AWS A 5.1: E6013	EN 2560-A: E 42 0 RC
	INE 46	AWS A 5.1: E6013	EN 2560-A: E 42 0 RC
	INE 47	AWS A 5.1: E6013	EN 2560-A: E 42 0 RR
	INE 48 A	AWS A 5.1: E6013	EN 2560-A: E 42 0 R
	INE VERTICAL	AWS A5.1: E6012	EN 2560-A: E 42 0 RC
	INE AR 150	AWS A5.1: E7024	EN 2560-A: E 42 0 RR
	INE AR 180	AWS A5.1: E7024	EN 2560-A: E 42 0 RR