

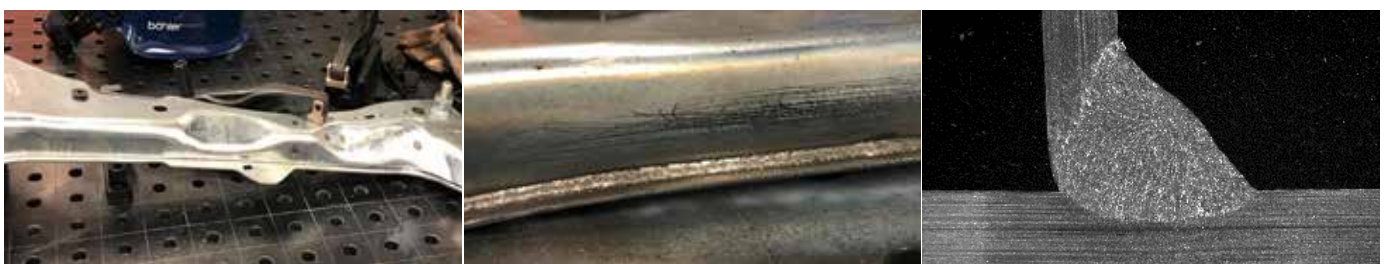
BÖHLER Q Zn GS

Metal cored wire for gas-shielded welding of galvanized and hot-dip galvanized sheets

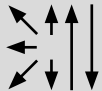
Product features	Product benefits	User benefits
» Designed for galvanized steel	» Low defect rate: porosity	» Productive welding
» Suitable for single run welding	» Easy slag removal on single run welds	» Less post weld cleaning
» Easy setting parameter	» Good wetting behaviour	» High travel welding speed
» Stable arc at lower welding parameter	» Low spatter emission at low welding parameter	» Easy Spatter removal from galvanized plate
» wide arc	» Compensate base material mis-alignment	» Lower pre-assembly work

BÖHLER Q Zn GS is a metalcored wire specially developed for single-layer welding of galvanized sheets (max. 4mm). It is suitable for Ar/CO₂ mixed gases: M20 and M21 according to EN ISO 14175, in DC (-) polarity. Features include: good weldability, excellent bead appearance, low spatter losses and high welding speed. Use Böhler Q Zn GS in connection with the compact inverter power source Uranos 2000SMC and get the ideal process package for mobile welding of galvanized sheet metal. For more information, see page 2.

The main applications are for general constructions with galvanized steels, automotive industry and air condition systems.



BÖHLER Q Zn GS

Classifications		Operating data		
EN ISO 17632-A	AWS A5.18/SFA-5.18	Welding positions	Polarity	Shielding gas
T3T Z M M21 1	E70C-GS		DC-	EN ISO 14175: M21-M20 Argon + 5 – 25% CO ₂

Typical chemical composition, all weld metal, wt. %				
Shielding gas	C	Si	Mn	Al
M21-M20	0.30	0.30	1.10	1.80

Mechanical properties, all weld metal (single values typical)					
Shielding gas	Condition	Yield strength R _{p0.2%} MPa	Tensile strength R _m MPa	Elongation A (L ₀ =5d ₀) %	CVN Impact toughness ISO-V KV J
M21 – M20	as welded	> 355	> 490	–	–

Overview spool types					
Ecodrum 250 kg		Wire basket spool BS300		Plastic spool S200	
	Octagonal drum Weight: 250 kg Dimensions: Height: 780 mm Ø: 510 mm Diameters: 1.0 mm 1.2 mm		Precision layer wound Weight: 16 kg Dimensions: Ø external 300 mm Ø internal 52 mm Width 100 mm Diameters: 1.0 mm 1.2 mm		Precision layer wound Weight: 5 kg Dimensions: Ø external 200 mm Ø internal 52 mm Width 47 mm Diameters: 1.0 mm 1.2 mm

Welding parameters							
Diameter [mm]	Plate thickness [mm]	Wire feed speed [m/min]	Welding current [A]	Arc-voltage [mm]	Shielding gas [EN ISO 14175]	Type of joint	Type of joint and scheme
1.0	2.0-3.0	4.0-6.5	130-160	17-18	M20/M21	Fillet	Stick-out 15-20 mm Push technique recommended
1.2	2.0-4.0	3.5-5.5	160-220	17-21			
1.0	2.0-3.0	3.5-4.0	130-160	16-18		Over lap	Stick-out 15-20 mm Push technique recommended
1.2	2.0-4.0	3.5-5.5	160-220	17-21			

Welding Machines	
<p>For the optimal welding performance with Böhler Q Zn GS, we recommend our special inverter power sources from the Uranos series.</p> <p>The compact Uranos 2000SMC is particularly suitable in connection with the G 250 torch. The welding parameters suitable for the respective application can be stored in several memory locations and thus enable best working conditions and saves time.</p>	