

SMG-6

AWS A5.18 ER70S-6
JIS Z3312 G 49 A 3 U C 6
EN ISO 14341-A G 42 3 C G4Si1

MIG WIRES FOR 490N/mm2 HIGH TENSILE STEEL

DESCRIPTION :

SMG-6 is a copper coated manganese-silicone wire for butt or fillet MAG welding of mild steel and 490N/mm2 grade steel. It performs with smooth wire feeding, stable arc and low spatter level.

APPLICATIONS :

It is for welding of general fabrication, pressure vessels, structural work and light to medium gauge sheet, pipe and tubular steels.

NOTE ON USAGE :

1. Wire-stick-out must be kept between 15 ~ 25mm.
2. Use 100% CO2 as sheilding gas.

WELDING POSITION:



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :(Shielding Gas: 100% CO2)

Weld Metal Analysis :

Carbon (C)	0.08
Manganese (Mn)	1.53
Silicon (Si)	0.88
Phosphorus (P)	0.018
Sulphur (S)	0.008

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)

YP N/mm2	450
TS N/mm2	550
EL%	30

TYPICAL IMPACT VALUES :

IV -30°C J	52
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APPROVALS :

ABS, LR

SUGGESTED WELDING PARAMETERS (DC <+>)

Size (mm)	0.8	0.9	1.0	1.2	1.6
Current (Amp)	50 ~ 180	50 ~ 200	80 ~ 250	100 ~ 350	200 ~ 500