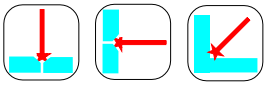
SG3

AWS A 5.18: ER70S-6
EN ISO 636-A- W 46 4 4Si1

DESCRIPTION

Copper coated solid Tig wire suitable for welding unalloyed steels, for C-Mn steels and for fine grain steels. The higher Si-Mn content gives a good bead appearance. Used for general construction, boilers fabrication etc.

WELDING POSITIONS	CURRENT	GAS
	DC-	Ar (I1),

BASE MATERIALS

S185, S235, S275, S355 Grade A, B, D, AH32 to DH36 L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB X42, X46, X52, X60 P235T1, P235T2, P275T1 P275T2, P355N P235GH, P265GH, P295GH, P355GH S275, S355, S420, S275M, S275

MECHANICAL PROPERTIES

Rm (Mpa)	***Rp 0,2 (Mpa)***	***A5 (%)***	***KV(j)***
590	500	26	80 J (-40° C)

WELD METAL COMPOSITION(%)

C	**Si**	**Mn**		
0,07	0,95	1,7		

PACKAGING & WELDING PARAMETERS

Dimension(mm)	0,8	1,0	1,2	1,6	2,0	2,4
	3,2	4,0				
Box(kg)	5	5	5	5	5	5

EQUIVALENT FILLER METALS

MMA	Meltolit 48 E, 48 E VD, 7016 E
MAG	Meltolit SG3
FCW, MCW	Megafil 713R, Megafil 710M