

# Meltolit

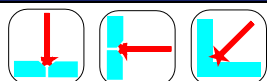
## SG3

AWS A 5.18: ER70S-6 ISO 14341-A: G 46 4 C1/M21 4Si1  
EN ISO 636-A- W 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

DC-

### GAS

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

<i>R<sub>m</sub></i> (Mpa)	<i>R<sub>p 0,2</sub></i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
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

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