

## SG 3

<b>CATEGORIE</b>	GMAW-GTAW massieve draad
<b>TYPE</b>	Copper coated welding wire for MAG welding of un and -low alloyed steels
<b>APPLICATIONS</b>	Shipbuilding, piping, root welding, bridges, repair, construction, offshore, car-plate welding etc...
<b>PROPERTIES</b>	Extreme easy to weld with excellent welding properties and increased yield strenght. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Weldable with Co2 and Mix gas.

<b>CLASSIFICATION</b>	AWS	A.5.18: ER 70 S-6 F-No. 6
	EN ISO	14341-A: G 46 4 M G4Si1 14341-A: G 42 4 C1 3Si 1 FM1

SUITABLE FOR	Materials	DIN	EN	ASTM
	shipbuilding	A, B, D, E, AH 32 - EH 36	same	Typical
	Unalloyed steels	St 33, St 37-2 - St 52-3	S185 - S355	A 258 / A 516
	boiler steels	H I, H III, 17Mn4, 19Mn5	P235GH, P355GH	A 662 / A 387
	pipe steels	St 35.8, St 45.8	P235T1/T2, P460NL2	A 738 / A 612
	-	StE 210.7 TM, StE 445.7 TM	L210 - L445MB	A 299
	Fine grain steels	StE 255 to StE 460	S235 - S460QL1	-
	API-standard	X 42, X65, X 70	X 42, X65, X 70	-
	Domex 460 MC			-

<b>APPROVALS</b>	TUV(12399.00),DB(42.206.02), CE approved
------------------	--



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	P	S
0,08	1,75	0,9	<0,025	<0,025

**MECHANICAL PROPERTIES:**

gas type	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
M21	>460	>560	>24	170	110		
C1	>420	>520	>24	120	90		

Recommended heat input : 8 - 13 KJ/cm.

**WELDING PARAMETERS PACKING:**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / drum	kg / pallet
0,8	18-24	60-200	K-300 / drum	15 / 250	1080 / 1000
1,0	18-32	80-300	K-300 / drum	15 / 250 / 500	1080 / 1000 / 500
1,2	18-35	120-380	K-300 / drum	15 / 250 / 500	1080 / 1000 / 500
1,4	20-38	150-480	K-300 / drum	15 / 250 / 500	1080 / 1000 / 500

<b>REDRYING TEMPERATURE</b>	not required
-----------------------------	--------------

<b>GAS ACC. EN ISO 14175:</b>	M21, C1
-------------------------------	---------