

Standards :

TS EN ISO 14341-A	:	G4 Si 1
TS EN ISO 636-A	:	W4 Si 1
EN ISO 14341-A	:	G4 Si 1
EN ISO 636-A	:	W4 Si 1
AWS A5.18	:	ER 70 S-6

**Chemical Composition of Welding Wire-
% (Typical) :**

C	Si	Mn
0.10	1.0	1.70

Mechanical Properties (MAG/M21) :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-40°C)	Elongation (L ₀ =5d ₀)(%)
min. 460	540 - 680	min. 47 J	min. 22

Typical Base Material Grades :

* E295, E360, S235J2G3-S355J2G3, P235T1-P355T1, P235T2,P355T2, L210NB-L415NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S420N, P255NH-P420NH, GE200-GE260

Features and Applications :

- * Used for the same welding purposes as SG-2.
- * Its strength is increased by Si-Mn.
- * Low spatter although used under CO₂ atmosphere.
- * Excellent wire feeding capability.
- * Shielding gases : TIG: Ar MAG: 20% CO₂ - 80% Ar or pure CO₂

Welding Positions :



Current Type :

TIG D.C.(-)
MAG D.C.(+)

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Weight Kg	Package Type
1.6 x 1000	1/16 x 39"	5	Carton Box
2.0 x 1000	5/64 x 39"	5	
2.4 x 1000	3/32 x 39"	5	
3.2 x 1000	1/8 x 39"	5	
4.0 x 1000	5/32 x 39"	5	
(0.8, 0.9, 1.0, 1.2, 1.4, 1.6)	(0.8, 0.9, 1.0, 1.2, 1.4, 1.6)	(1, 5, 15, 18, 50, 250, 400)	D/K 300 D 200 D 100 ECO PACK BIG PACK
0.8	0.030"	15	
1.0	0.040"	15	
1.2	0.047"	15	
1.6	0.062"	15	

Approvals :

SG3 / M24 : TSE, DB, TÜV, CE, GL, GOST-R, SEPPO