



Meltolit

SG3

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

DESCRIPTION

Copper coated solid wire suitable for single pass or multipass welding on non alloy 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/Co2 (M21),
Co2(C1)

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_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
590	500	26	80 J (-40° C)

WELD METAL COMPOSITION(%)

C	Si	Mn		
0,1	0,9	1,7		

PACKAGING & WELDING PARAMETERS

Dimension(mm)	0,8	1,0	1,2	1,6
Spool size(kg)	1/5/16	1/5/16	5/16	16
Wire feeding/min	3,4-11	2,9-8,4	4,9-8,5	4,9-8,5
Current(A)	50-140	80-190	180-280	200-400
Voltage(V)	16-22	16-24	20-28	22-40

EQUIVALENT FILLER METALS

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