

SDA 3 (ITW WELDING GMBH)

CATEGORY GMAW-GTAW Solid wires

TYPE Copper coated welding wire for MAG and Tig welding of un and -low alloyed steels

APPLICATIONS Shipbuilding, piping, root welding, bridges, repair, construction, offshore, car-plate welding etc... Suitable for unalloyed and fine grain steels up to 460N/mm² Yield strength.

PROPERTIES Extreme easy to weld with excellent welding properties and increased yield strength. High world wide excepted quality with controlled cast and helix for semi and or semi-automatic applications. Weldable with Co₂ and Mix gas.

CLASSIFICATION

AWS	A.5.18: ER 70 S-6 5.18M: ER48S-6
EN ISO	14341-A: G 46 4 M G4Si1 14341-B: G 55A 4 M G6
DIN: W.Nr.	1.5130
DIN	8559: SG3

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, X60, X65	X 42, X60, X65	-

APPROVALS TÜV, ABS, BV, DNV, GL, LR, DB, CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	P	S
0,08	1,75	0,9	-	-	-	<0,025	<0,025

MECHANICAL PROPERTIES:

heat treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW and SR	>460	530-680	>22	>70	>55		

AW: as welded / SR: stress relieved / Recommended heat input : 8 - 13 KJ/cm.

WELDING PARAMETERS PACKING:

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool / drum	kg / pallet
0,8	18-24	60-200	K-300 / drum	16 / 300	1024 / 600
1,0	18-32	80-300	K-300 / drum	16 / 300	1024 / 600
1,2	18-35	120-380	K-300 / drum	16 / 300	1024 / 600

REDRYING TEMPERATURE not required