

SG3 Tig

CATEGORY	GMAW-GTAW Solid wires		
TYPE	Copper coated welding wire for GTAW welding of un and -low alloyed steels		
APPLICATIONS	Shipbuilding, piping, root welding, bridges, repair, construction, offshore, car-plate welding etc...		
PROPERTIES	Extreme easy to weld with excellent welding properties and increased yield strenght.		
CLASSIFICATION	AWS	A.5.18: ER 70 S-6	
	EN ISO	636-A: W 46 4 M G4Si1	
	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, X65, X 70	X 42, X65, X 70	-
	Domex 460 MC			

APPROVALS	TUV(12399.00),CE approved
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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:

Shielding gas type	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	
I1	>460	>560	>24	170	110		

Recommended heat input : 8 - 13 KJ/cm.

WELDING PARAMETERS / PACKING:

Welding Parameters		Packing	
D (mm)	Current (A) DC-	single (kg)	master (kg)
1,6 x 1000	50-90	5	25
2.0 x 1000	70-110	5	25
2.4 x 1000	110-180	5	25
3.2 x 1000	150-250	5	25

REDRYING TEMPERATURE	not required
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GAS ACC. EN ISO 14175:	I1
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