

**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 <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-40°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> )(%)
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 CO<sub>2</sub> atmosphere.
- \* Excellent wire feeding capability.
- \* Shielding gases : TIG: Ar MAG: 20% CO<sub>2</sub> - 80% Ar or pure CO<sub>2</sub>

**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