

AS MIG SG3 PERFORMANCE



MIG/MAG Welding Wire for Mild Steels

Classification

TS EN ISO 14341-A : G 42 3 C1 4Si1 / G 46 5 M21-M32 G4Si1
 AWS A5.18 : ER70S-6

General Description

AS SG3 PERFORMANCE is a copper coated gas metal arc welding wire in 15 kg spools or 250 kg drums. It is particularly designed for semiautomatic and full-automatic GMAW applications. Working temperature can range between -50 to 450°C.

CO or 80 % Ar- 20 % CO are used for gas shielding.

Chemical Composition (w%), Typical, Wire

C	Si	Mn
0.08	1.00	1.70
0.06 *	0.60 *	1.20 *

(*) Typical weld metal composition (CO gas shielding)

Approvals

DB, GOST, NAKS, SEPRO, TSE, TÜV
GL

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 480 N/mm²
 Tensile Strength : 590 N/mm²
 Elongation (L=5d) : 25 %
 Impact (ISO-V) : 60 J (-50°C)

Shielding Gases (ISO 14175 / EN 439)

MAG: M21- Ar + 5-25% CO₂
 C1 - CO₂ (100%)

Current Type and Polarity: DC (+)

Materials to be Welded

	DIN	EN
General Structural Steels	St 44, St 44-2, St 44-3, St 52, St 52-3 St 37-4, St 44-4, St 52-4 St 50-2, St 60-2, St 70-2 C 10 - C 35 ; Ck 10 - Ck 35	S275, S355 P235TR2 - P355T2 E295, E335, E360 C10 - C35
Fine Grained Steels	StE 255 - StE 460 WStE 255 - WStE 355	S255N - S460N P255NH - P355NH
Pipe Materials	StE 210-7 - StE 415-7 X42, X46, X52, X60 (API 5LX)	L210 - L415NB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 HI, HII	P295GH, P355GH P235GH, P265GH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, C, D, E AH32 - EH36	- -
Cast Steels	GS-38, GS-45, GS-52	GE200, GE240, GE260

Packing and Diameter Informations

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight	Drum Weight
MIG/MAG Wire	x	x	x	x	-	-	-	15 kg	250 kg / 500 kg

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Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as 1 suitable for general guidance. Fumes : Consult information on Welding Safety Sheet, available upon request.