

MIG WIRE FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SMG-4 is a high tensile steel wire for 490N/mm² grade steel. It is suitable for thin steel plates and all-positional welding.
- If is for welding of general fabrication, ship building, vehicle, structural work and bridges joint welding.

NOTE ON USAGE :

- Use shielding gas with flow rate 15~25 l/min.
- Wire-stick-out must be kept between 15~25mm.
- Keep nozzle and tips clean before usage.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (Shielding Gas : 100% CO₂)

C	Mn	Si	P	S
0.082	1.40	0.82	0.012	0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL : (Shielding Gas : 100% CO₂)

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -20 °C/-30 °C J(Kgf-m)
470(48.0)	540(55.1)	28	104(10.6)/62(6.3)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter(mm)	0.8	0.9	1.0	1.2	1.6
Current (Amp)	50-180	50-200	80-250	100-350	250-500