

MIG WIRE FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SMG-8 is a solid wire for 490N/mm² high tensile steel. Contains with titanium element and suitable with high current and thick plate welding.
- It is for welding ship building, vehicle, steel structure and bridge.

NOTE ON USAGE :

- Use shielding gas with flow rate 20~25 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	Ti
0.07	1.48	0.75	0.015	0.008	0.16

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 -30 °C J(Kgf-m)
465(47.4)	570(58.1)	31	55(5.6)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter(mm)	1.0	1.2	1.4	1.6
Current (Amp)	50-220	100-350	150-450	250-550