

MAG•MIG Wire

S-G

AWS A5.18M ER49S-G / A5.18 ER70S-G
JIS Z 3312 (a)G57JA2UC4 (b)YGW11
ISO 14341-A-G 42 2 C1 Z

Product Features:

- Suitable for welding of mild and 490 N/mm² grade high tensile strength steel.
- Ti element contained in wire for improving oxidation resistance, less spatter loss.
- High welding performance, suitable for high current welding.
- High welding speed, deep penetration and high welding efficiency.

Applications:

- Suitable for welding of mild and 490 N/mm² high tensile strength steel structures on vehicles, machinery, bridges, pressure vessels and shipbuilding.

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Ti	Fe
0.05	0.80	1.50	0.012	0.015	0.18	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value	
			(-0°C) J	(-20°C) J
491	558	32	150	138

Size (mm) & recommended welding parameters (A) DC+

Diameter	1.2	1.4	1.6
Flat position	120~350	240~380	260~450
Horizontal fillet position	120~350	240~380	260~450
Shielding Gas	CO ₂		

Note:

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