

# MAG / MIG wire

## S-4

AWS A5.18M ER49S-4 / A5.18 ER70S-4  
JIS Z 3312 G52A2UC4  
ISO 14341-A-G 42 2 C1 3Si1

### Product Features:

- Suitable for welding of mild and 490 N/mm<sup>2</sup> grade high tensile strength steel.
- Suitable for thin plate for all positions.
- High welding performance.
- Available for low to moderate current range, good arc stability, less spatter loss and good bead appearance.

### Applications:

- Suitable for welding of mild and 490 N/mm<sup>2</sup> grade high tensile strength steel structures on vehicles, general electrical, light steel, pipe, steel constructions, bridge and shipbuilding.

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Fe
0.07	0.84	1.48	0.011	0.018	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-20°C) J
451	542	30	102

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

Diameter	0.9	1.0	1.2
Flat position	60~200	80~230	120~350
Vertical position	60~100	80~180	120~150
Shielding Gas	CO <sub>2</sub>		

### Note:

- Not recommend for vertical position (upward and downward) on structure parts.

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