

MAG•MIG wire/rod

S-6

AWS A5.18M ER49S-6 / A5.18 ER70S-6
JIS Z 3312 (a)G55A3UC6 (b)YGW12
ISO 14341-A-G 42 3 C1 3Si1

Product Features:

- Suitable for welding of mild and 490 N/mm² high tensile strength steel.
- Suitable for thin plate and all position welding.
- Higher Si and Mn elements contained in wire for improving oxidation resistance capability.

Applications:

- Suitable for welding of mild and 490 N/mm² 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
0.08	0.83	1.48	0.014	0.013	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value	
			(-30°C) J	(-50°C) J
439	557	26	80	49

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

Diameter	0.8/0.9	1.0	1.2	1.6
Flat position	60~200	80~230	120~350	260~400
Vertical position	60~100	80~180	120~150	----
Shielding Gas	CO ₂ OR 80%Ar+20%CO ₂			

Note:

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

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