

MAG wire

GW12

AWS A5.18M ER49S-6 / A5.18 ER70S-6
JIS Z 3312 (a)G52A3UC6 (b)YGW12
ISO 14341-A-G 42 4 C1 3Si1

Product Features:

- Suitable for welding of mild and 490 N/mm² high tensile strength steel.
- Suitable for thin plate for all positions 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 structure, bridge and shipbuilding.

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Fe
0.06	0.87	1.53	0.023	0.010	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	(-30°C) J	(-40°C) J
455	550	32	131	111	91	63

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			

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