

MAG•MIG Wire

GW15

JIS Z 3312 (a)G55A2UM3 (b)YGW15
ISO 14341-A-G 42 2 M21 2Si

Product Features:

- Suitable for welding of mild and 490 N/mm² grade high tensile strength steel.
- Available for wider welding current range.
- Good arc stability, low spatter loss and good bead appearance even in very low welding current.

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
0.07	0.55	1.32	0.012	0.014	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-20°C) J
510	568	30	149

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

Diameter	1.2	1.4	1.6
Flat position	120~350	230~330	260~380
Vertical position	120~150	200~280	240~320
Shielding Gas	80%Ar + 20%CO ₂		

Note:

- Typical all weld metal mechanical properties obtained from 80%Ar+20%CO₂ shielding gas welding test.
- Not recommend for vertical position (upward and downward) on structure parts.

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