

MIG WIRE FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SMG-52 is a solid wire for 490N/mm² high tensile steel. Adding on the slight aluminum(Al), titanium(Ti) and zirconium(Zr) metallic elements, the weldability is great on mechanical properties.
- Suitable for pressure vessels, petro and chemical industry for root pass welding.

NOTE ON USAGE :

- Use shielding gas with flow rate 20~25 l/min.
- Wire-stick-out must be kept between 15~25mm.
- Keep nozzle and tips clean before usage.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (Shielding Gas : 100% CO₂)

C	Mn	Si	P	S	Al	Ti	Zr
0.038	1.21	0.51	0.015	0.008	0.06	0.08	0.04

TYPICAL MECHANICAL PROPERTIES OF WELD METAL : (Shielding Gas : 100% CO₂)

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -30 °C J(Kgf-m)
474(48.4)	545(55.6)	29	90(9.2)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter(mm)	0.8	0.9	1.0	1.2	1.6
Current (Amp)	50-180	50-200	80-250	100-350	250-500