

MIG WIRE FOR $\geq 550\text{N/mm}^2$ HIGH TENSILE STRENGTH STEEL

DESCRIPTION & APPLICATIONS :

- SMG-60 is a solid wire of mild steel and 550N/mm² grade steel. Used for high tensile strength steel structure, and with wider range of current and stable arc.
- Used for Bridge, construction, engineering machinery, harbor machinery, and pressure vessel.

NOTE ON USAGE :

- Proper gas flow should be 20~25 l/min.
- Wire-stick-out must be kept between 15 ~ 25mm.
- Maintaining the cover and TIP of welding gun.

WELDING POSITION :



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

C	Mn	Si	P	S	Mo
0.074	1.41	0.73	0.013	0.006	0.20

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -30 °C J(Kgf-m)
510(52.0)	590(60.2)	28	50(5.1)

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