

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

DESCRIPTION & APPLICATIONS :

- SMG-60N 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%) : (100%CO₂ , MIX 80%Ar+20%CO₂)

C	Mn	Si	P	S	Ni	Gas
0.08	1.15	0.71	0.012	0.008	1.03	CO ₂
0.09	1.32	0.75	0.013	0.009	1.16	MIX

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (100%CO₂ , MIX 80%Ar+20%CO₂)

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -60 °C J(Kgf-m)	Gas
510(52.0)	585(59.7)	29	68(6.9)	CO ₂
542(55.3)	614(62.7)	27	74(7.6)	MIX

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