

MIG WIRE FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SMG-6 is a premium, multiple deoxidized solid wire. It is suitable for thin steel sheet with 490N/mm² grade welding.
- It is for all-positional welding on ship building, vehicle, structural work and general fabrication.

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
0.08	1.53	0.88	0.012	0.008

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/-45 °C J(Kgf-m)
450(45.9)	550(56.1)	30	100(10.2)/60(6.1)

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	200-500