

**TECHNICAL DATA SHEET NOVOFIL SG3 SPECIAL BRONZE WIRES**

Classification of the material according to the international spec.

AWS A5.18: ER70S-6  
 DIN 8559: SG3  
 ISO 14341-A (2011) G 46 4 M21 G4 SI 1

Welding wires to be used for both Co2 / M2x-M3x mixed combination gases The wire is specially coated by a bronze film. Available from sizes 0,80 to 1.60mm on spools 1/kg-25/kg and megapacks 80/kg-450/kg

**Materials :** St. 37 – St 52, H I – III, 17 Mn 4, steel St 35 , St. 35.8, St. 45.8, SIE 420.

**Typical chemical content ( %)**

<i>C</i>	<i>Mn</i>	<i>Si</i>
0.07-0.09	1.50-1.70	0.80-1.00

**Mechanical properties of welded material as per DIN 32 525 ( min.)**

Tested in laboratory in accordance to UNI EN ISO 148-1:2011

<b>Tensile Strength :</b> (N/mm <sup>2</sup> )	> = 530	CO2/M21
<b>Yield strength:</b> (N/mm)	> = 630	CO2/M21
<b>Elongation:</b> (A 5 %)	27 – 35	CO2/M21

**RECOMMENDED  
WELDING  
PARAMETERS**

DIAMETER WIRE	SHORT	ARC	SPRAY	ARC
<i>MM</i>	<i>AMPERE</i>	<i>VOLT</i>	<i>AMPERE</i>	<i>VOLT</i>
0,80	80-130	18-20	170-250	23-28
0,90	130-170	18-22	180-260	24-29
1,00	140-180	18-25	220-280	24-29
1,20	140-200	18-25	320-370	26-29
1,40	140-200	18-25	350-400	26-30
1,60	140-200	18-25	380-420	26-30

The used gas is M 21 ( 80% Argon - 20% Co2) - Including 92%Ar – 8%CO2

**Power type : DC+**      **Wire speed: 12-15mts/min**      **Gas: 12-14 lt/minute**