

## **TECHNICAL DATA SHEET NOVOFIL (SG1) WELDING WIRES**

Classification of the material according to the international spec.

AWS A5.18: ER70S-3  
DIN 8559: SG1  
EN 440: G 42 3 M G3 Si 1

Welding wire to be used under protective gases Co2 for general applications.  
The wire is spooled on plastic or basket reels from 1 kg up to 25 kgs and drums from 75 up to 500 Kgs.

### ***Materials***

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

### ***Typical chemical details ( %)***

<i>C</i>	<i>Mn</i>	<i>Si</i>
0.07-0.08	1.18-1.25	0.60-0.80

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

**Welding wire to be used under Protective gas Co2 / M21 mix gas for general applications**

<b>Tensile Strenght:</b> (N/mm2)	> = 530	CO2/M21
<b>Yeld strenght:</b> (N/mm)	> = 420	CO2/M21
<b>Elongation:</b> (A 5 %)	24 – 29	CO2/M21

### ***Amperage & Power***

<i>Dia. (mm).</i>	<i>0,80</i>	<i>1,00</i>	<i>1,20</i>	<i>1,60</i>
Amperage	70 - 210	90 – 310	130 – 350	220 – 410
Volts	18 - 23	18 – 28	18 – 30	24 – 34
Power	CC-EP	CC-EP	CC-EP	CC-EP