

TECHNICAL DATA SHEET NOVOFIL SG3 - WELDING WIRES

Classification of the material according to the international spec.

AWS A5.18: ER70S-6
 DIN 8559: SG3
 EN 14341-A (2011) G4 Si1
 G 46 4 M21 G4 Si 1

Welding wire to be used under protective gases Co₂ for general applications. The wire can be copper coated, bronze coated, uncoated.
 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>
0.07-0.09	1.53-1.70	0.80-1.10

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

Tensile strength : (Mpa)	> = 560	CO ₂ /M21
Yield strength: (Mpa)	> = 520	CO ₂ /M21
Elongation: (A 5 %)	24 – 29	CO ₂ /M21

Amperage & Power

<i>Dia. (mm).</i>	<i>0,80</i>	<i>1,00</i>	<i>1,20</i>	<i>1,60</i>
Amperage	60 – 185	80 – 310	120 – 380	220 – 550
Volts	18 – 24	18 – 32	18 – 35	28 – 38
Power	CC-EP	CC-EP	CC-EP	CC-EP