

Classifications

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|---------------------|------------------|--------------|------------------|
| EN ISO 14341-A:2008 | : G 46 4 C G4Si1 | AWS A5.18-05 | : ER70S-6 |
| | : G 46 4 M G4Si1 | JIS Z 3312 | : G 55 A 4U C G6 |
| EN ISO 14341-B:2008 | : G 49A 4U C G6 | | |
| | : G 49A 4U M G6 | | |

Description

- For butt and fillet welding of ship-building, bridges, structural steel, steel buildings, machineries and vehicles
- Served as both carbon dioxide and mixture gas, and stable arc performance in almost welding current
- A wide range of use due to low spatter and all welding position
- Suited for application of sheet metal on high welding current without burn through

Typical chemical composition of wire (%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.08 | 0.99 | 1.63 | 0.015 | 0.007 |

Typical mechanical properties of all-weld metal

| | Y.S (MPa) | T.S (MPa) | El. (%) | IV (J) | | Remarks |
|----------------|--------------|--------------|------------|--------|-------|-----------------|
| | | | | -30°C | -40°C | |
| AWS A5.18 | min. 400 | min. 480 | min. 22 | ≥ 27 | | CO ₂ |
| EN ISO 14341-A | min. 460 | 530~680 | min. 20 | | ≥ 47 | CO ₂ |
| Example | 510 | 620 | 27 | 110 | 105 | CO ₂ |
| | 560 | 660 | 24 | 90 | 80 | Mix |

Operating data

| Dia.(mm) | | 1.2 | 1.4 |
|-------------------|------------------|-----------|-----------|
| Current (Amp.) | Flat (PA/1G) | 100 ~ 350 | 140 ~ 400 |
| | Vertical (PF/3G) | 50 ~ 180 | 100 ~ 250 |
| | Overhead (PE/4G) | 50 ~ 180 | 100 ~ 250 |

Polarity and Shielding gas

- DCEP (DC+)
- CO₂ : 100% CO₂
- Mix : Ar+20% CO₂ (15~25ℓ /min.)