



SG-3 V3L5 HP SPECIAL

CLASSIFICATION

AWS A5.18/A5.18M: ER70S-6
EN-ISO 14341-A : G 46 5 M21 4Si1 / G 42 3 C1 4Si1

WELDING POSITIONS



GENERAL DESCRIPTION

- Solid wire type SG3 for semi-automatic and robotic welding applications
- Good feedability, consistent welding performance
- Very good weldability, stable arc, and low spatter
- Increased levels of Mn & Si

SHIELDING GASES

M21 Mixed gas Ar+> 15-25% CO2
C1 Active gas 100% CO2

APPROVALS

TÜV DB CE

CHEMICAL COMPOSITION [W%] TYPICAL WIRE

C	Mn	Si
0,08	1,7	0,85

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical Values	Shielding gas	Condition	Yield Strength [MPa]	Tensile Strength [MPa]	Elongation [%]	Impact ISO-V [J]	
						-30°C	-50°C
	M21	AW	530	630	28		100
	C1		480	585	26	80	

EXAMPLES OF MATERIALS TO BE WELDED

Steel grade	Standard	Type
General structural steel	EN 10025	S185 - S235 - S275 - S355
Ship plate	ASTM A131	Grade A,B,D AH32 to DH36
Pipe steel	API	X52 - X60 - X70
	EN 10208-1	L210 - L240 - L290 - L360
	EN 10208-2	L240MB/NB - L290MB/NB - L360MB/NB - L415MB/NB
Boiler/Pressure vessel steel	EN 10028-2	P235GH - P265GH - P295GH - P355GH
Fine grained steel	EN 10025 part 3	S275 - S355 - S420
	EN 10025 part 4	S275M/ML - S355M/ML - S420M/ML - S460

This material overview cannot be all-encompassing. Contact us for questions on material not mentioned on this datasheet

PACKING AND AVAILABLE SIZES

Unit	Diameter [mm]	0.8	1.0	1.2	1.6
	B300-16kg	+	+	+	+
	ECO Drum 250kg	+	+	+	
	ECO Drum 500kg		+	+	+

Other sizes and packaging on request

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance