

FIL SG2

PRO FOR INDUSTRY



Mig Mag Welding Wires

AWS/ASME SFA 5.1 ER70s-6
EN ISO 14341-A G42 2C G3Si1

Unalloyed wire electrode for MIG/MAG welding of general structural steels, pipe steels, and cast steels using CO₂ or mixed shielding gases, depending on thickness of the base metal. Welding of thin walled steels, thin sheet welding in automotive industry. Butt and fillet welding of vehicles, building, ships, machinery, and bridges in all positions Pipe parts.

Characteristics on Usage:

- Suitable for high speed welding of steel sheets by short circuiting transfer in all positions.
- Keep the distance between tip and base plate metal 6~15mm for 250 Amp. And under or within 15~25mm for more than 250 Amp. Of welding current

Typical chemical composition of all-weld-metal (%)

C	Si	Mn
0.08	0.50	1.05

Typical mechanical properties of all-weld-metal

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation %	Charpy V-notch J (30°C)
450	550	29	70

Welding positions



APPROVALS: GL, ABS, LR, BUREAU VERITAS

