

SM-55H

High tensile steels

Conformances

JIS Z3312 YGW18
EN ISO 14341-B G S18

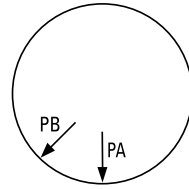
Applications

- Shipbuilding
- Automotive
- Structural fabrication

Features

- Good performance with high-current
- CO₂ gas
- High Efficiency
- Deep penetration

Welding Position



Current

DC +

Shielding Gas

100% CO₂

Diameter / Packaging

Diameter	Spool			Ball Pac		
	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
0.8 (0.033)	√	√	√	√	√	√
0.9 (0.035)	√	√	√	√	√	√
1.0 (0.040)	√	√	√	√	√	√
1.2 (0.045)	√	√	√	√	√	√
1.4 (0.052)	√	√	√	√	√	√
1.6 (1/16)	√	√	√	√	√	√

Typical Chemical Composition of the Wire(%)

C	Si	Mn	P	S	Ti
0.07	0.89	1.95	0.013	0.007	0.18

Typical Mechanical Properties of All-Weld Metal

	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
As welded with 100% CO ₂	550 (79,800)	630 (91,500)	28	0 (32)	110 (81)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm(in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045in), DC +					
100% CO ₂ Gas	20 (3/4)	14.5 (570)	280	31	7.3 (16.1)
		17.0 (670)	320	34	8.6 (19.0)
		21.0 (830)	350	37	10.6 (23.3)

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX