

## Applications

Butt and fillet welding of ships, steel structures and machinery.

## Characteristics on Usage

SM-70GS is a solid wire for flat and fillet welding and is to be used with a high current welding with Ar+CO<sub>2</sub> mixed gas.

As this wire contains special elements, its weldability and impact values are excellent.

## Notes on Usage

- ① Use with Ar+15~20% CO<sub>2</sub> gas.
- ② Flow quantity of shielding gas should be 25ℓ /min. approximately.
- ③ Use wind screen against wind.

### Welding Position



1G (PA)    2F (PB)

### Current

DC +

### Shielding Gas

Ar+CO<sub>2</sub>

### Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S	Ti
0.06	0.62	1.21	0.015	0.006	0.10

### Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
480 (69,700)	550 (79,800)	28	-20 (-4)	90 (66)

### Approval

### I Packing (Including Ball Pac)

LR	Dia. (mm)	1.2	1.4	1.6	Spool(kg)	15	20
	(in)	.045	.052	1/16			
	Ball Pac						

### Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	80~300	150~350	200~390