



GMAW / MIG

## B&H MIG Wire

COPPER COATED C-Mn STEEL GMAW FILLER WIRE FOR 500-540 MPA TENSILE STRENGTH STEEL

<b>CLASSIFICATION :</b> EN ISO 14341-A/B	AWS A/SFA 5.18	CSA W48	BIS	<b>APPROVALS:</b>
	ER70S-6	B-G 49A 3C1 S6	IS6419 S4	RDSO/BHEL/RoHS

### KEY FEATURES :

- C-Mn steel solid wire
- Uniform copper coating
- Smooth wire feeding
- Can be use with 100% CO<sub>2</sub>, Ar+CO<sub>2</sub>
- Higher level of de-oxidizers makes it suitable for applications where dirt, rust or mill-scale is present
- Radiographic quality weld

### WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
CO <sub>2</sub>	12-18	10-20
80% Ar+20%CO <sub>2</sub>	17-22	10-20

### TYPICAL APPLICATIONS :

- Construction and mining equipment
- Pressure vessels, LPG Cylinders
- Root pass pipe welding, Tanks, Structural steel components
- Railcar construction and repair, Frame fabrication
- Thin sheet metal, Auto body
- Farm implements, Steel casings
- High-speed robotic, automatic and semi-automatic welding applications
- Shaft build up, General fabrication

### STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

### CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	S	P	Cu*
Specification	0.06-0.14	1.40-1.60	0.80-1.0	0.025 max	0.025 max	0.50 max

\* Including Cu in the coating

### MECHANICAL PROPERTIES OF ALL WELD METAL :

Condition	Shielding Gas	UTS, MPa	YS at 0.2%, MPa	EL%	CVN Impact at -30°C, J	
Specification	As Welded	100% CO <sub>2</sub>	500-640	420 min	22 min	47 min
Specification	As Welded	80Ar + 20CO <sub>2</sub>	530-680	460 min	24 min	47 min

Hardness, 3 Layer: 200 BHN max (irrespective of type of gas used) With mixed gas mechanical properties will be higher.

### PARAMETERS - PACKING DATA :

Ø, mm	Voltage, V	Amperage, A	Kg
0.8	18 - 30	80 - 250	15
1.0	18 - 30	100 - 300	15
1.2	20 - 34	120 - 350	15
1.6	24 - 36	150 - 400	15