



## MIG A60

### Classification

AIR 9117 : A 60

### Description & Applications

Solid wire for gas (Ar + CO<sub>2</sub>) metal arc welding of unalloyed and low alloyed steels such as XC18S, E26-4, E36-4... Product available copper coated or not.

**Main applications:** Aeronautic industry.

### Typical Chemical Composition ( % )

	C	Si	Mn	Al	Ti	P	S	Si+Al+Ti	P+S
Min			0.80						
Max	0.12	0.60	1.20			0.020	0.020	0.90	0.040
Type	0.08	0.57	1.0	0.005	0.003	0.015	0.015	<0.90	<0.040

### All Weld Metal Mechanical Properties

	R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
Min	-	-	-
Max			
Type	460	550	25

### Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current ( A )	Voltage ( V )	
GMAW = +	1.0 1.2	80 - 260 100 - 360	17 - 32 18 - 34	ISO 14175: M21 (Ar/CO <sub>2</sub> ) 12-15 l/min

FT En-ME01-191113

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