



MIG F57

Old reference: MIG SG2

Classification

AWS A5.18 : ER70S-6
ISO 14341-A : G 42 4 M21 3Si1

ISO 14341-A : G 42 3 C1 3Si1

Description & Applications

Copper coated solid wire for gas (Ar + CO₂ or 100% CO₂) metal arc welding of low alloyed standard construction / boiler steels like E36 (S235-S355; P235-P310). Good mechanical properties.

Main applications: For general metal constructions, ship building etc. Advise in piping systems, for root passes and high quality assemblies...

Base material:

Construction steels for general use, Tube steels, Ship steels:

EN	Ship steels	ASTM
S185 – S355	Quality A and B	A285 grade C
P235 – P355		A442 grade 55, 60
L210 – L360		A414 grade C, D, E, F
		A515 grade 55, 60, 65

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Al	Ti+Zr	V	P	S
Min	0.06	0.80	1.40									
Max	0.14	1.00	1.60	0.15	0.15	0.15	0.35	0.02	0.15	0.03	0.025	0.025
Type	0.07	0.85	1.45	0.05	0.04	0.01	0.10	0.01	0.01	0.01	0.015	0.010

All Weld Metal Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	420	500	22	-40°C >47
Max		640		
Type	430	530	28	-40°C 55

* Shielding gas: M21 (Ar + CO₂)

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	60 - 200	16 - 28	ISO 14175: M21 (Ar/CO ₂) C1 (100% CO ₂) 12-15 l/min
	1.0	80 - 260	17 - 32	
	1.2	100 - 360	18 - 34	

FT En-MA05-191113

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr