

Artikelnummer	Omschrijving
05000001	MIG SM-70 SG2 Kleine spoel D200 dia 0,6mm - 5kg
05000002	MIG SM-70 SG2 Kleine spoel D200 dia 0,8mm - 5kg
05000003	MIG SM-70 SG2 Kleine spoel D200 dia 1,0mm - 5kg
05000004	MIG SM-70 eco SG2 ijzer dia 0,8mm
05000005	MIG SM-70 eco SG2 ijzer dia 1,0mm
05000006	MIG SM-70 eco SG2 ijzer dia 1,2mm
05000007	MIG SM-70 eco SG2 plastic dia 0,8mm
05000008	MIG SM-70 eco SG2 plastic dia 1,0mm
05000009	MIG SM-70 eco SG2 plastic dia 1,2mm
05000013	MIG SM-70 SG2 ijzer dia 1,0mm
05000014	MIG SM-70 SG2 ijzer dia 1,2mm
05000021	MIG SM-70 SG2 ijzer dia 1,4mm
05000015	MIG SM-70 SG2 ijzer dia 1,6mm
05000016	MIG SM-70 SG2 plastic dia 0,8mm
05000017	MIG SM-70 SG2 plastic dia 1,0mm
05000018	MIG SM-70 SG2 plastic dia 1,2mm
05000019	MIG SM-70 SG2 plastic dia 1,6mm
05000023	MIG SM-70 SG2 dia 0,8mm - 250kg Ball pack
05000024	MIG SM-70 SG2 dia 1,0mm - 250kg Ball pack
05000025	MIG SM-70 SG2 dia 1,2mm - 250kg Ball pack
05000033	MIG SM-70 SG2 Blank dia 1,0mm
05000051	MIG SM-70 SG2 dia 1,0mm - 300kg Ball pack
05000052	MIG SM-70 SG2 dia 1,6mm - 500kg Ball pack

SM-70

AWS A5.18 / ASME SFA5.18 ER70S-6
 JIS Z3312 YGW12
 EN ISO 14341-A G 42 2 C 3Si1
 EN ISO 14341-A G 42 3 M 3Si1

Toepassingen

Voor het lassen van staalstructuren, zoals voertuigen, machines en bruggen.


Characteristics on Usage

SM-70 is a solid wire designed for all position welding by short-circuiting type transfer. As the deposition efficiency is high and penetration is deep, highly efficient welding can be performed.

Notes on Usage

- ① Use with CO₂ /Argon+15~25% CO₂ gas.
- ② The Flow of quantity of shielding gas should be approximately 25 ℓ /min.
- ③ Use wind screen against wind.
- ④ Keep distance between tip and base metal 6~15mm for less than 250A, and 15~25mm for more than 250A of welding current.

GMAW

Welding Position	Current	Shielding Gas
 1G 2F 3G 4G (PA) (PB)(PF.PG)(PE)	DC+	CO ₂ /Ar+ CO ₂

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S
0.07	0.83	1.48	0.017	0.020

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)
430 (62,400)	540 (78,400)	28	-29 (-20)	70 (52)

Approval | Packing (Including Ball Pac)

KR, ABS, LR, BV, DNV, GL, NK, CWB, TÜV, NAKS, MRS, CE, DB	Dia. (mm)	1.0	1.2	1.4	1.6	Spool(kg)	5	15	20
	Ball Pac								

Sizes Available and Recommended Currents (Amp.)

Size mm	1.0	1.2	1.6
F & HF	50~220	100~320	170~390
V-up, OH	50~140	50~140	-

Artikelnummer	Omschrijving
05000029	MIG SM-70EN SG3 dia 0,8mm - 250kg Ball Pack
05000030	MIG SM-70EN SG3 dia 1,0mm - 250kg Ball Pack
05000031	MIG SM-70EN SG3 dia 1,2mm - 250kg Ball Pack
05000054	MIG SM-70EN SG3 dia 1,0mm - 300kg Ball Pack
05000055	MIG SM-70EN SG3 dia 1,2mm - 300kg Ball Pack
05000069	MIG SM-70EN eco SG3 ijzer dia 0,8mm
05000070	MIG SM-70EN eco SG3 ijzer dia 1,0mm
05000071	MIG SM-70EN eco SG3 ijzer dia 1,2mm
05000072	MIG SM-70EN eco SG3 plastic dia 0,8mm
05000073	MIG SM-70EN eco SG3 plastic dia 1,0mm
05000074	MIG SM-70EN eco SG3 plastic dia 1,2mm
05000075	MIG SM-70EN SG3 ijzer dia 1,0mm
05000077	MIG SM-70EN SG3 ijzer dia 1,2mm
05000078	MIG SM-70EN SG3 plastic dia 1,0mm
05000079	MIG SM-70EN SG3 plastic dia 1,2mm

SM-70EN

AWS A5.18 / ASME SFA5.18 ER70S-6
 JIS Z3312 YGW12
 EN ISO 14341-A G 42 2 C 4Si1
 EN ISO 14341-A G 46 4 M 4Si1

Toepassingen

Voor het lassen van staalstructuren, zoals voertuigen, machines en bruggen.
 Lasdraad heeft hogere rek grens en treksterkte dan de SM-70. Spat armer lassen.

Characteristics on Usage

SM-70EN is a solid wire designed for used Ar+CO₂ mixed gas. Its property is similar to SM-70 and better than bead appearance, lower spatter for SM-70.

Notes on Usage

- ① Use with CO₂ /Argon+15~25% CO₂ gas.
- ② The Flow of quantity of shielding gas should be approximately 25ℓ /min.
- ③ Use wind screen against wind.
- ④ Keep distance between tip and base metal 6~15mm for less than 250A, and 15~25mm for more than 250A of welding current.

Welding Position	Current	Shielding Gas
 1G 2F 3G 4G (PA) (PB)(PF.PG)(PE)	DC +	CO ₂ /Ar+ CO ₂

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S
0.08	0.95	1.70	0.019	0.015

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)
461 (66,900)	560 (81,200)	29	-29 (-20)	95 (55)

Approval	I Packing (Including Ball Pac)								
TÜV, DB, CE, DNV, GL	Dia. (mm)	0.9	1.2	1.4	1.6	Spool(kg)	5	15	20
	(in)	.035	.045	.052	1/16	(lbs)	11	33	44
	Ball Pac								

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	0.9 (.035)	1.2 (.045)	1.6 (1/16)
F & HF	50~220	100~320	170~390
V-up,OH	50~140	50~140	-

Artikelnummer	Omschrijving
06000001	MIG Hyundai T1 SM 110 1,0mm
06000002	MIG Hyundai T1 SM 110 1,2mm

SM-110

AWS A5.28 ER110S-G

Toepassingen

Voor snijgereedschappen, messen voor landbouwwerktuigen, rollen voor koudwalsen

Characteristics on Usage

Characteristic features include excellent start properties, trouble-free feeding at high wire speeds and lengthy feed distances, a very stable arc at high welding currents; extremely low levels of spatter, low fume emission, reduced contact tip wear and improved protection against corrosion of the wire.

Notes on Usage

- ① Use with 100%Ar or Ar+2~20%CO₂ gas.
- ② Flow quantity of shielding gas should be 25ℓ /min. approximately.
- ③ Use the wind-screen against wind.

Shielding Gas

Ar + CO₂ (M21)

Current

Pulse

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.089	0.75	1.83	0.015	0.012	0.3	1.90	0.52

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)
700 (103,000)	887 (128,700)	19.4	-40 (-40) -60 (-76)	82 (60) 69 (51)

Approval

I Packing (Including Ball Pac)

Dia. (mm)	1.0	1.2	Spool(kg)	5	12.5	15
(in)	.039	.045	(lbs)	11	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)
F & HF	170 ~ 270

Artikelnummer	Omschrijving
07000006	MIG Hyundai SC 600 HM 1,2mm
07000007	MIG Hyundai SC 600 HM 1,6mm

SC-600HM

Toepassingen


Voor snijgereedschappen, messen voor landbouwwerktuigen, rollen voor koudwalsen

Characteristics on Usage

SC-600HM is a metal cored wire without slag for hardfacing application with Ar-CO₂ mixed gas. It is high resistance to cracking and toughness.

Notes on Usage

- ① Preheat at 150°C(302°F) and more than that in general.
- ② Use with Ar + 20% CO₂ shielding gas.

Welding Position	Current	Shielding Gas
 1G (PA)	DC +	Ar + 20%CO ₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr	Mo
0.5	0.3	1.5	6.5	0.35

Typical Mechanical Properties of All-Weld Metal

Preheat temp.°C(°F)	Postheat	Heat Treatment	Hardness(HRc)
150 (302)	-	-	58~62

Approval | Packing

	Dia. (mm)	1.2	1.6	Spool(kg)	15
	(in)	.045	1/16	(lbs)	33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2(.045)	1.6(1/16)
F	250~300	300~380

FCAW