



## Nexus SG3

### Copper coated solid mild steel wire for Semi-automatic and Robotic MIG/MAG welding applications

Mild steel MIG/MAG wires for welding mild and medium tensile Structural steels and plates using CO<sub>2</sub> and Mixed gases. This grade offers improved arc stability at currents >300amps resulting in superior bead shape and low levels of spatter.

#### International Standards

|                       |                        |
|-----------------------|------------------------|
| <b>BS EN 440:1995</b> | <b>AWS A5.18- 2001</b> |
| <b>G4Si1</b>          | <b>ER 70S - 6</b>      |

#### Typical All-Weld Metal Analysis (wt%)

|             |             |             |              |              |
|-------------|-------------|-------------|--------------|--------------|
| <b>C</b>    | <b>Si</b>   | <b>Mn</b>   | <b>S</b>     | <b>P</b>     |
| <b>0.06</b> | <b>0.67</b> | <b>1.19</b> | <b>0.014</b> | <b>0.014</b> |

#### Typical All-Weld Metal Mechanical Properties

|  |  |                         |                                      |
|--|--|-------------------------|--------------------------------------|
| <b>Yield Strength<br/>N/mm<sup>2</sup></b> | <b>Tensile Strength<br/>N/mm<sup>2</sup></b> | <b>Elongation<br/>%</b> | <b>Impact Strength<br/>-20°C (J)</b> |
| <b>467</b>                                 | <b>557</b>                                   | <b>23</b>               | <b>130</b>                           |

#### Welding Positions

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| <b>All Positions including vertical down</b> |
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#### Materials

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| <b>All mild and medium carbon steels with a toughness requirements down to -20°C</b> |
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#### Packaging

|                                 |            |            |            |            |
|---------------------------------|------------|------------|------------|------------|
| <b>Size mm</b>                  | <b>0.8</b> | <b>1.0</b> | <b>1.2</b> | <b>1.6</b> |
| <b>Plastic spools 15 kg</b>     | ✓          | ✓          | ✓          | ✓          |
| <b>Wire basket 15 kg</b>        | -          | ✓          | ✓          | ✓          |
| <b>250 kg Round Bulk Packs</b>  | ✓          | ✓          | ✓          | ✓          |
| <b>550 kg Square Bulk Packs</b> | ✓          | ✓          | ✓          | ✓          |

#### Additional Information

|                                   |  |
|-----------------------------------|--|
| <b>CE Certified</b>               | <b>Constructional products directive (CPD)</b>                           |
| <b>Certification</b>              | <b>BS EN 10204:2004 Type 2.2</b>   |
| <b>Material safety data sheet</b> | <b>MSDS 01</b>   |
| <b>BOC Shielding Gas MIG</b>      | <b>Argoshield Light (&lt;3 mm)/Universal (3-10 mm)/Heavy (&gt;10 mm)</b> |
| <b>Related Nexus Products</b>     | <b>Nexus E6013/E7024 and Nexus A15/A18</b>                               |