

# PRODUCT DATA SHEET

## Afrox MIG 3000



Afrox MIG 3000 is a standard grade welding wire produced from high quality double deoxidized rod. The wire is copper coated for increased shelf life.

### Welding Procedure

MIG 3000 exhibits a low spatter volume and is suitable for dip, spray arc and pulsed arc transfer welding using shielding gases such as Argoshield® 5, Argoshield® Light, Argoshield® Heavy and Argoshield® Universal or CO<sub>2</sub>. Shielding gas flow rates of 15-20 l/min should be used.

### Classifications

AWS	A5.18	ER 70S-6
SABS	145	Grade A
BS EN	14341	G42 2 C G4Si1

### Typical Chemical Analysis (All weld metal)

% Carbon	0,07 - 0,15	% Sulphur	0,035 max
% Manganese	1,4 - 1,85	% Phosphorous	0,03 max
% Silicon	0,8 - 1,15		

### Typical Mechanical Properties (All weld metal using CO<sub>2</sub> gas)

Shielding Gas	CO <sub>2</sub>
Testing Condition	As welded
0,2% Proof Stress	430 MPa min
Tensile Strength	510 - 570 MPa
% Elongation on 50 mm	26 min
Charpy V-Notch at +20°C	110 J min
Charpy V-Notch at 0°C	80 J min
Charpy V-Notch at -20°C	47 J min

### Packing Data

Diameter (mm)	Item Number
0,9	W033931
1,0	W033932
1,2	W033933

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