



# Technical Data Sheet

Prepared by	Approved by	PDS No & Rev.	Issue date.	Page
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## HTW-50 (SG2)

Copper Coated mild steel solid wire for Gas shielded welding wire

### General

HTW-50 (SG2) is a double deoxidised copper coated carbon steel MIG filler wire for use with CO<sub>2</sub> or CO<sub>2</sub>/Ar mixed gases.

**Shielding Gas:** 100% CO<sub>2</sub>, Mixed gas

### Classifications Weld Metal

GB/T: ER50-6

AWS A 5.18: ER70S-6

IS6419:S4

DIN8559:SG2 EN G3 Si1

JIS: YGW12

CSA Standard W48-01 ER49S-6

### Approvals

ABS 3YSA C1

LR 3S 3YS H15 C1

CWB C1 M21

TUV C1, M21-M33 DIN439

DB C1, M2, M3 DIN EN439

CCS 3YSM CO<sub>2</sub>

### Welding Parameters

Diameter	Position	Current(A) Range
0.8mm	all	40-140
1.0mm	all	50-220
1.2mm	all	80-350
1.6mm	all	120-550

For and on behalf of  
CHANGZHOU HUATONG WELDING INDUSTRY CO., LTD  
常州華通焊業股份有限公司

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Authorized Signature(s)

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**Chemical Composition of wire (%)**

	Min	Max		Min	Max
C	0.06	0.14	P		0.025
Mn	1.40	1.60	S		0.025
Si	0.80	1.00	Ni		0.15
			Mo		0.15
			Al		0.02
			Ti+Zr		0.15

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**Mechanical Properties of Weld Metal**

Properties	Typical Value
Yield Stress (Mpa)	425
Tensile Stress(Mpa)	532
Elongation(%)	32
Impact Value(J) (-29 °C)	89

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**Standard Packing:**

Diameter	Plastic Spool	Metal Spool	Pail
0.8mm	1kg,5kg,15kg	16kg	250kg
1.0mm	1kg,5kg,15kg,20kg	16kg	250kg
1.2mm	1kg,5kg,15kg,20kg	16kg	250kg
1.6mm	5kg,15kg,20kg	16kg	350kg

Other Diameters available: 0.6mm(.023"), 0.9mm(.030"), 1.14mm(.045"), 1.4mm(.052").

Spool types: 1kg/D100, 5kg/D200, 15kg/D270 White, 15kg/D270 Black, 15kg/D300 Black, 20kg/D270Black, 20kg/D270white, 16kg/K300.

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