

MagMate® Mild Steel MIG Wire

GMAW Wire, Mild Steel, Copper coated.



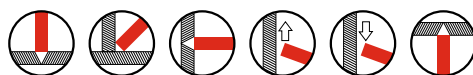
0.9 mm, 15 kg spool in packaging

Description MagMate® Mild Steel MIG wire is a quality copper-coated MIG wire produced from double deoxidised rod. MagMate® Mild Steel MIG wire is an excellent choice for welding on metal with medium to high presence of mill scale or rust. The wire is designed for both single and multiple pass welding in all positions. The copper coating on the wire increases the shelf life and ensures good electrical conductivity.

Application MagMate® Mild Steel MIG wire is recommended for welding of mild and medium tensile steels and is an excellent choice for general steel construction, sheet metal applications and structural welding.

Storage Recommendations Store all wire spools in their original packaging in a controlled environment of less than 50% relative humidity.

Welding Positions



WARNING

Welding can give rise to electric shock, excessive noise, eye and skin burns due to the arc rays, and a potential health hazard if you breathe in the emitted fumes and gases. Read all the manufacturer's instructions to achieve the correct welding conditions and ask your employer for the Safety Data Sheets. Refer to www.boc.com.au or www.boc.co.nz

Specifications

Coating type	Copper-coated
Classifications	AWS/ASME-SFA A5.18 ER70S-6
	AS/NZS 14341 B-G 49A 3U C S6, B-G 49A 3U M S6

Recommended Shielding Gases

- Argoshield Light
- Argoshield Universal
- Argoshield Heavy
- Argoshield 40
- Flow rate 15-20 L/min.
- Argoshield 52
- Argoshield 54
- Argoshield 100
- Welding Grade CO₂

Chemical Composition, wt% – Wire

	C	Si	Mn
Typical	0.07	0.84	1.44

Mechanical Properties – All Weld Metal

Typical (as welded)	Using Argoshield	Using CO ₂
Yield strength	452 MPa	420 MPa
Tensile strength	560 MPa	525 MPa
Elongation	27%	31%
Impact energy, CVN	84J min av @ -30°C	72J min av @ -30°C

Packaging Data**5 kg Handi spool (200 mm Ø)**

Diameter	0.6 mm	0.8 mm	0.9 mm	–
Part No.	706B0506	706B0508	706B0509	–

15 kg Spool (300 mm Ø)

Diameter	0.6 mm	0.8 mm	0.9 mm	1.0 mm (NZ)	1.2 mm	1.6 mm
Part No.	706B06-1	706B08-1	706B09-1	706B10-1	706B12-1	706B16-1

250 kg Smoothpak Drum

Diameter	0.9 mm	1.0 mm	1.2 mm	–
Part No.	706B09250	706B10250	706B12250	–

Welding Parameters

Diameter	0.6 mm	0.8 mm	0.9 mm	1.0 mm	1.2 mm	1.6 mm
Current range (A)	40-100	60-150	90-220	100-280	120-320	200-400
Voltage range (V)	12-22	15-24	16-30	18-30	18-32	25-35