

# SM-55H

High tensile steels

## Conformances

JIS Z3312 YGW18  
EN ISO 14341-B G S18

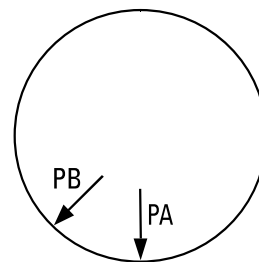
## Applications

- Shipbuilding
- Automotive
- Structural fabrication

## Features

- Good performance with high-current
- CO<sub>2</sub> gas
- High Efficiency
- Deep penetration

## Welding Position



## Current

DC +

## Shielding Gas

100% CO<sub>2</sub>

## Diameter / Packaging

Diameter mm (in)	Spool			Ball Pac		
	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
0.8 (0.033)	✓	✓	✓	✓	✓	✓
0.9 (0.035)	✓	✓	✓	✓	✓	✓
1.0 (0.040)	✓	✓	✓	✓	✓	✓
1.2 (0.045)	✓	✓	✓	✓	✓	✓
1.4 (0.052)	✓	✓	✓	✓	✓	✓
1.6 (1/16)	✓	✓	✓	✓	✓	✓

**Typical Chemical Composition of the Wire(%)**

C	Si	Mn	P	S	Ti
0.07	0.89	1.95	0.013	0.007	0.18

**Typical Mechanical Properties of All-Weld Metal**

	YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
As welded with 100% CO <sub>2</sub>	550 (79,800)	630 (91,500)	28	0 (32)	110 (81)

**Typical Welding Parameters**

Diameter, Polarity Shielding Gas	CTWD mm(in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
<b>1.2mm (0.045in), DC +</b>					
100% CO <sub>2</sub> Gas	20 (3/4)	14.5 (570)	280	31	7.3 (16.1)
		17.0 (670)	320	34	8.6 (19.0)
		21.0 (830)	350	37	10.6 (23.3)