

TM-60

AWS A5.28 ER80S-G
EN ISO 16834-B G 55 3 C1 Z
EN ISO 16834-B G 55 6 M21 Z
JIS Z 3312 YGWJ18/YGWJ19

Characteristics and Applications:

TM-60 is a solid wire for butt or fillet MAG welding of mild steel and 590N/mm² grade steel. It also can be operated with a wider range of welding currents than other solid CO₂ wires.

It is suitable for welding high tensile strength steel used in construction welding, vehicles and bridges.

Notes on usage:

1. E.S.O. (Electrode Stick Out) must be kept between 15-25mm.
2. Proper welding conditions must be adopted according to the purpose as the bead appearance and penetration are both varied widely.
3. Use 100% CO₂ or Ar + CO₂ gas mixture as shielding gas.
4. Control within the optimal range of welding conditions for this wire as possible.

Typical chemical composition of wire metal (wt%):

	C	Mn	Si	P	S	Mo	Cu
AWS	Not Specified						
EN ISO	Not Specified						
Typical value	0.08	1.51	0.67	0.015	0.015	0.32	0.03

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -30°C (-20°F)
AWS	Not Specified	≥550(80)	Not Specified	Not Specified
EN ISO	≥460(67)	550-740(80-107)	≥17	-30°C ≥ 47J
Typical value	510(74)	598(87)	28	52(38)

Sizes and recommended current range (DC <+>):

Diameter (mm)	1.2	1.6
Amps	90-350	170-400

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