

**MERIT<sup>®</sup> JG™-56****CONFORMANCE**

- ASME SFA-5.18 AWS A5.18: ER70S-6

**APPROVALS**

- ISO 9001 Quality Management System

**APPLICATIONS**

- General thin plate welding
- Pipeline construction
- Boiler and pressure vessel
- Ship building

**WELDING POSITIONS**

All Positions

**PRODUCT FEATURES**

- GTAW solid wire for mild steels
- Use with 100% Ar shielding gas
- High quality, pure and consistent raw rod
- Particularly good for root pass welding

**DIAMETER AVAILABLE**

- 1.6×1000mm
- 2.0×1000mm
- 2.4×1000mm
- 3.2×1000mm
- 4.0×1000mm

**STANDARD PACKAGING**

- Plastic Tube: 5KG, 10KG

*\* Please contact your local Lincoln Electric sales office for alternative types of packaging.*

**MERIT<sup>®</sup> JG<sup>™</sup>-56****CHEMICAL COMPOSITIONS OF SOLID WIRE(Wt-%), TYPICAL**

MERIT <sup>®</sup> JG <sup>™</sup> -56	C	Si	Mn	S	P	Cu
<b>AWS Requirement</b>	0.06-0.15	0.80-1.15	1.40-1.85	≤0.035	≤0.025	≤0.50
<b>Typical Value</b>	0.07	0.83	1.48	0.015	0.015	0.12

**MECHANICAL PROPERTIES OF ALL-WELD-METAL, TYPICAL**

MERIT <sup>®</sup> JG <sup>™</sup> -56	Condition	Shielding Gas	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	CVN Impact (J) @ -30°C
<b>AWS Requirement</b>	As-welded	100% Ar	≥400	≥480	≥22	≥27
<b>Typical Value</b>			460	550	30	160

**RECOMMENDED WELDING PARAMETERS (DC-)**

Diameter x Length (mmxmm)	1.2X1000	1.6X1000	2.0X1000	2.4X1000	3.2X1000	4.0X1000
<b>Current Range (A)</b>	120-180	140-200	160-240	180-260	220-280	240-300

**Customer Assistance Policy**

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com.cn](http://www.lincolnelectric.com.cn) for any updated information.

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