


M500 DC+

STEEL

DESCRIPTION

Specially engineered **solid MIG wire** with titanium alloy added for welding **galvanized steel**, **aluminized** and **zinc plate steel** parts. The M500 formula allows reduction of zinc oxide formation for better quality of weld.

CHARACTERISTICS

- **Special formulation to increase the cleaning effect and fluidity**
- Exceptionally easy to weld
- Very low spatter
- Porosity free deposit
- Excellent bead appearance
- High welding deposition

TYPICAL APPLICATION

Farm machinery, body work and specifically for galvanized, aluminized and zinc plate steel. Design for welding of dirty, rusty and painted parts.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal and cracks with the **Soudotec 212 SP** or **Soudotec G12** electrode.

MECHANICAL PROPERTIES

Tensile strength: 72 600 psi (500 MPa)
Elongation: 28%

WELDING PARAMETERS

Gas :	Ar/CO ₂ mixture		
Diameter :	1.2 mm (.045")	0.8 mm (.030")	0.6 mm (.024")
Amperage :	130 – 340 A	60 – 200 A	45 – 125 A
Voltage :	17 – 30 V	14 – 26 V	14 – 25 V
Stick-out :	3/8" - 3/4"	3/8" - 3/4"	3/8" - 3/4"
Gas flow rate (c.f.h) :	30 to 40	30 to 40	30 to 40
Packaging :	Spool of 4.5 kg and 15 kg : 0.6 mm, 0.8 mm, 1.2 mm		

Also available in electrodes: **Soudotec 222**

Rév.: 21_08

Specialized welding alloys and technology. For technical assistance or for ordering: