

**Soudotec 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 <sub>2</sub> mixture		
Diameter:	1.2 mm (.045")	0.8 mm (.030")	0.6 mm (0.024")
Amperage:	100 - 350 A	60 -180 A	40 -70 A
Voltage:	18 - 33 V	18 - 20 V	17 - 18 V
Stick-out:	3/8" - 3/4"	3/8" - 3/4"	3/8 - 3/4"
Gas flow rate (c.f.h):	30 - 40	30 - 40	30 - 40

Packaging: Spool of 4.5 kg and 15 kg

Also available in electrodes: **Soudotec 222**

Rév.: 7\_01

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