

ER70S-6

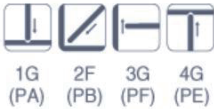
AWS A5.18 ER70S-6

EN ISO 14341-A : G 42 3 C1/M21 Z 3Si1

Description:

A gas shield copper coated carbon steel welding wire for fabrication of mild steel. It provides excellent usability with stable arc, less spatter, good bead appearance. The weld metal has excellent mechanical performance and less sensitive to pores. Used for carbon steel and alloy steel with 500MPa tensile strength structures welding, and high speed welding of sheet plates and pipelines.

Welding Position:



Diameters:

0.6mm, 0.8mm, 0.9mm, 1.0mm, 1.2mm, 1.4mm, 1.6mm.

Typical Mechanical Properties:

| | |
|-------------------------------------|-----|
| Tensile strength(MPa): | 560 |
| Yield strength(MPa): | 470 |
| Elongation(%): | 26 |
| Impact values(≥ 27)/(-30°C): | 80 |

Typical Chemical Compositon:

| C | Mn | P | S | Si | Ni | Cr | Mo | Cu | V |
|------|------|-------|-------|------|------|------|------|------|-------|
| 0.08 | 1.67 | 0.010 | 0.008 | 0.92 | 0.02 | 0.01 | 0.01 | 0.07 | 0.001 |

Welding Current:

| Diameter(mm) | | 0.8 | 1.0 | 1.2 | 1.6 |
|--------------|------|--------|--------|---------|---------|
| Current/A | F/H | 50-200 | 80-250 | 100-360 | 170-390 |
| Current/A | V/OH | 50-140 | 80-160 | 80-220 | -- |

Note:

1. Rusty, water, oil and other impurity should be cleaned before welding.
2. Shield gas: 100%CO₂ or 80%Ar+20% CO₂; Gas speed: 15-25L/Min
3. **Tig rods ER70S-6 1.6mm, 2.0mm, 2.4mm, 3.2mm available**