

ER70S-6 Cooper Free

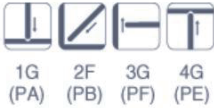
AWS A5.18 ER70S-6

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

Description:

An environmental-friendly non-copper carbon steel welding wire for fabrication of mild steel. It is featured with less welding fume due to the special surface treatment without cooper coating.

Welding Position:



Diameters:

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

Typical Mechanical Properties:

Tensile strength(MPa):	560
Yield strength(MPa):	440
Elongation(%):	31
Impact values(≥ 27)/(-30°C):	89

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu	V
0.08	1.32	0.010	0.008	0.68	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.
3. Gas speed: 15-25L/Min