

CHARACTERISTICS

- 1, Less sensitive to impurities on weld piece
- 2, Higher strength than typical ER70S-6
- 3, Uniform bead formation
- 4, Can be used for multiple pass on steels where rusty and dirty surfaces are not cleaned before welding

TYPICAL APPLICATIONS

- 1, General Fabrication
- 2, Steel Industry
- 3, Automotive



SIZE	1.2mm	1.0mm	0.9mm	0.8mm
AMPS	90-350A	80-230A	75-200A	50-180A

CLASSIFICATION

AWS A/SFA 5.18 ER70S-6
EN ISO 14341-A : G 42 4 C1 4Si1
EN ISO 14341-A : G 46 5 M21 4Si1

WELDING POSITIONS (ISO/ASME)



EQUIVALENT TO

CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

C	Si	Mn	P	S
0.08	0.92	1.72	0.011	0.012

AVAILABLE SIZES (DIA.)

0.8mm/0.9mm/1.0mm/1.2mm/1.6mm

PACKAGING DETAILS

1/5/15kg Spools/250/350kg Drums

CURRENT TYPE

DC+

MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Shielding Gas	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation(%)	Charpy V notch (J)
AW	100% CO ₂	480	570	28	-40 C 76
	80% Ar+20% CO ₂	490	588	29	-50 C 80

Note:
Shielding gas : 100% CO₂ or 80% Ar+20% CO₂; Gas speed 15-25L/Min.

