

### CHARACTERISTICS

1. Better wetting
2. Flatter bead shape
3. Faster travel speeds
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

0.8mm

0.9mm

1.0mm

1.2mm

AMPS

50-75A

75-125A

90-165A

140-280A

### CLASSIFICATION

AWS A5.18 ER70S-6  
EN ISO14341-A G42 2 C/M21 3Si1

### WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

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

| C    | Mn   | Si   | S     | P     |
|------|------|------|-------|-------|
| 0.08 | 1.67 | 0.92 | 0.012 | 0.015 |

### AVAILABLE SIZES (DIA.)

0.6mm/0.8mm/0.9mm/1.0mm/1.2mm/1.6mm

### PACKAGING DETAILS

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

### EQUIVALENT TO

|                       |                 |
|-----------------------|-----------------|
| Lincoln SuperArc L-56 | Esab Weld 70S-6 |
| Hyundai SM-70         | Kiswel KC-28    |
| Indura 70S-6          | Infra 70S-6     |

### CURRENT TYPE

AC / DC +

### MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

| Condition | Shielding Gas              | Yield Strength (Mpa) | Tensile Strength (Mpa) | Elongation(%) | Charpy V notch (J) |
|-----------|----------------------------|----------------------|------------------------|---------------|--------------------|
| AW        | 100% CO <sub>2</sub>       | 470                  | 560                    | 28            | -30°C 76           |
|           | 80% Ar+20% CO <sub>2</sub> | 485                  | 575                    | 28.5          | -30°C 83           |

Note:

① Shielding gas: 100% CO<sub>2</sub> or 80% Ar+20% CO<sub>2</sub>; Gas speed 15-25L/Min.

