

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 A5.18 ER70S-6
EN ISO 14341-A : G 42 4 C1 4Si1
EN ISO 14341-A : G 46 5 M21 4Si1

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

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.

