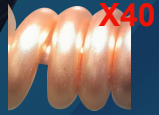


CHARACTERISTICS

1. Better wetting
2. Flatter bead shape
3. Excellent coating quality ensures continuous wire feeding performance in robot welding
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 A/SFA 5.18 ER70S-6
EN ISO14341-A G42 2 C/M21 3Si1

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

C	Mn	Si	S	P
0.08	1.67	0.92	0.012	0.015

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

AVAILABLE SIZES (DIA.)

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

PACKAGING DETAILS

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

CURRENT TYPE

AC / DC +

EQUIVALENT TO

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

MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

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

Note:

① Shielding gas: 100% CO₂ or 80% Ar+20% CO₂; Gas speed 15-25L/Min.

