



**GMAW/GTAW C-Mn STEEL**  
**AUTOMIG 1**

COPPER COATED C-Mn STEEL GMAW FILLER WIRE FOR 500 MPa TENSILE STRENGTH STEEL



**CLASSIFICATION :** EN ISO 14341-A

AWS A/SFA 5.18

**APPROVALS :**

G 42 3 C1 3Si1  
G 46 4 M21 3Si1

ER70S-6

ABS/BV/DNV/IRS  
IBR/RDSO/CE

**KEY FEATURES :**

- C-Mn steel solid wire
- Uniform copper coating
- Smooth wire feeding
- Can be use with 100% CO<sub>2</sub>, Ar+CO<sub>2</sub>
- Higher level of de-oxidizers makes it suitable for applications where dirt, rust or mill-scale is present
- Radiographic quality weld

**WELDING POSITION :**



**DCEP**

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
Co <sub>2</sub>	12-18	10-20
80Ar+20CO <sub>2</sub>	15-25	10-20

**TYPICAL APPLICATIONS :**

- Construction and mining equipment
- Pressure vessels, LPG Cylinders
- Root pass pipe welding, Tanks, Structural steel components
- Railcar construction and repair, Frame fabrication
- Thin sheet metal, Auto body
- Farm implements, Steel casings
- High-speed robotic, automatic and semi-automatic welding applications
- Shaft build up, General fabrication

**STORAGE / HANDLING :**

Keep dry and follow handling instructions mentioned on the box

**CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :**

	C	Mn	Si	S	P	Cu*
Specification	0.06-0.14	1.40-1.60	0.80-1.0	0.025 max	0.025 max	0.50 max

\* Including Cu in the coating

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

Condition	Shielding Gas	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J	
Specification	As Welded	100% CO <sub>2</sub>	500-640	420 min	22 min	47 min
Specification	As Welded	80Ar + 20CO <sub>2</sub>	530-680	460 min	22 min	47 min

Hardness, 3 Layer: 200 BHN max

**PARAMETERS - PACKING DATA :**

Ø, mm	Voltage, V	Amperage, A	Kg/Spool	MIGPAC DRUM, Kg
0.8	17-27	80-250	15	100 / 250
1.0	18-30	100-350	15	100 / 250
1.2	20-34	120-400	15	100 / 250
1.6	24-36	150-450	15	100 / 250

**EQUIVALENT :**

SMAW Electrode: **Supabase X Plus**

FCAW Wire: **Automig FC 71T-1**