GMAW/GTAW C-Mn STEEL

AUTOMIG 70S-G

COPPER COATED GMAW SOLID WIRE FOR WELDING C-Mn STEEL

CLASSIFICATION : EN ISO 14341-A AWS A/SFA 5.18

G 42 3 C G4Si1	ER 70S-G
G 46 3 M G4Si1	

KEY FEATURES :

- C-Mn steel GMAW solid wire
- Uniform copper coating
- Smooth wire feeding
- Can be use with 100% CO_2, Ar+CO_2
- Suitable for applications where dirt, rust or mill-scale is present
- All Position Welding capability
- Radiographic quality weld

WELDING POSITION : DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
CO_2	12-18	10-20
80Ar+20CO_2	17-22	10-20

TYPICAL APPLICATIONS :

- Pressure vessels, LPG Cylinders
- Construction and mining equipment
- Pipe and Structural steel welding
- Thin sheet metal, Auto body
- General fabrication
- Farm implements, Steel casings
- High-speed robotic, automatic and semi-automatic welding applications

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	1.60-1.90	0.80-1.15	0.025 max	0.025 max	0.35 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_2	520 min	420 min	22 min	47 min
Specification	As Welded	80Ar + 20CO_2	550 min	460 min	24 min	47 min

Hardness, 3 Layer: 210 BHN max (irrespective of type of gas used) with mixed gas mechanical properties will be higher.

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