



MCAW C-Mn STEEL
AUTOMIG MC 70C-6C

METAL CORED WIRE FOR MIG / MAG WELDING



CLASSIFICATION : AWS A/SFA 5.18 **APPROVALS:**

E70C-6CH4 -

KEY FEATURES :

- Metal cored wire suitable with CO₂ shielding gas
- Good weldability, minimal or no slag
- Excellent bead appearance
- Exceptional mechanical properties at low temperatures
- High deposition rate
- Suitable for single and multi pass welding
- Best suited for automated and robotized applications

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
100% CO ₂	14-20	15-25

TYPICAL APPLICATIONS :

- Welding of Carbon, C-Mn and similar types including fine grained steels
- Ship building, Boilers
- Suitable for joining SA 36/36M (P.No.1), SA 285/285M Gr.A/B/C (P.No.1)
- Pressure Vessels, Pipe steels

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	S	P
Typical	0.06	1.4	0.6	0.01	0.01
Specification	0.12 max	1.75 max	0.90 max	0.03 Max	0.03 Max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	550	500	28	72
Specification		480 min	400 min	22 min	27 min

Diffusible H₂ Content: <4 ml/100 gm

PARAMETERS - PACKING DATA :

Ø, mm	Voltage, V	Amperage, A	Kg/Spool
1.2	24-30	120-350	15
1.6	26-32	180 - 400	15