



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

METAL CORED WIRE FOR MIG / MAG WELDING



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

E70C-6MH4    CE

**KEY FEATURES :**

- Metal cored wire suitable with Ar-CO<sub>2</sub> 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
80Ar+20CO <sub>2</sub>	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 during storage and handling

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :**

	C	Mn	Si	S	P
Typical	0.05	1.5	0.8	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	571	520	30	80
Specification		480 min	400 min	22 min	27 min

Diffusible H<sub>2</sub> 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