



GMAW/GTAW C-Mn STEEL
AUTOMIG 70S-6 N

COPPER FREE C-Mn STEEL GMAW FILLER WIRE



CLASSIFICATION : AWS A/SFA 5.18 EN ISO 14341-A CSA W48 **APPROVALS :**

ER70S-6 G 42 4 M 3Si1 B-G 49A 3C1 S6 CWB/CE

KEY FEATURES :

- Copper free C-Mn steel solid wire
- Smooth and stable arc
- Lowest spatter, Smooth feedability
- Best anti-rust properties
- Low smoke levels
- Best suited for high speed welding
- Operates at high current density
- 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 ₂	12-20	10-20
80Ar+20CO ₂	18-25	10-20

TYPICAL APPLICATIONS :

- Construction and mining equipment
- Structural steel components
- Frame fabrication, Tanks
- General fabrication
- Auto body
- 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	1.40-1.60	0.80-1.0	0.025 max	0.025 max	0.20 max
	Ni	Cr	Mo	V	Al	Ti+Zr
Specification	0.05 max	0.05 max	0.05 max	0.01 max	0.01 max	0.05 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -40°C, J
Specification As Welded	500-640	420 min	22 min	47 min

Hardness, 3 Layer: 200 BHN max (irrespective of type of gas used)

PARAMETERS - PACKING DATA :

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

MIGPAC DRUM in 100 / 250 Kgs can be made available on request.