



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% CO₂, Ar+CO₂
- 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 ₂	12-18	10-20
80Ar+20CO ₂	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	
Specification	As Welded	100% CO ₂	500-640	420 min	22 min	47 J min @-30°C
Specification	As Welded	80Ar + 20CO ₂	530-680	460 min	22 min	47 J min @-40°C

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**