



# AUTOMIG I

GMAW C-Mn Steel

AWS A/SFA 5.18 **ER70S-6**

### CLASSIFICATION:

**EN ISO 14341-A**

G 42 3 C1 3Si1

G 46 4 M21 3Si1

G 46 4 M24 3Si1

**IS 6419**

S4-C/M 504

**CSA W48**

B-G 49A 3C1 S6

### KEY FEATURES:

- C-Mn steel solid wire
- Uniform copper coating
- Smooth wire feeding
- Can be use with 100% CO<sub>2</sub>, Ar+CO<sub>2</sub>
- Higher level of de-oxidizers makes it suitable for applications where dirt, rust or mill-scale is present
- Radiographic quality weld

**APPROVALS:** ABS/BV/DNV/IRS/IBR/LRA/NPCIL/RDSO/CE/CWB/BIS

### TYPICAL APPLICATIONS:

- Truck bodies, Storage tanks
- Construction equipment
- Light gauge work
- Steel furniture, Machinery
- Foundry equipment, Barges
- Tacking work, Small parts repair

### TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

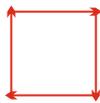
C	Mn	Si
0.075	1.45	0.85

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	Shielding Gas	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J	
						@-30°C	@-50°C
Typical	As Welded	100% CO <sub>2</sub>	570	470	25	50	-
Typical	As Welded	80Ar + 20CO <sub>2</sub>	580	480	26	80	50

**Special Test:** HIC and SSCC (NACE)

### PARAMETERS - PACKING DATA:

Ø, mm	Wt / Spool, kg	 <b>DCEP</b>  <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	All Positions  
0.8	15		
1.0	15		
1.2	15		
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
CO <sub>2</sub>	12-18
80Ar+20CO <sub>2</sub>	17-22

Available in Plastic Spool & Wire Basket. Also Available in 100, 150 & 250Kg Drums