

## ❖ Product Description

- |                                                                               |                                                   |
|-------------------------------------------------------------------------------|---------------------------------------------------|
| I. A non-copper coated wire                                                   | IV. Smooth feedability and low spatter occurrence |
| II. Has excellent arc stability and uniform weld bead appearance              | V. Radiographic weld quality                      |
| III. Smoke emission is significantly reduced due to absence of copper coating |                                                   |

## ❖ Range of Application

- |                                                      |                                                               |
|------------------------------------------------------|---------------------------------------------------------------|
| I. Extremely suitable for welding of steel structure | III. Good for fillet and butt weld in automobile industry     |
| II. Widely used in automobile industry               | IV. Can be used for general fabrication in almost any segment |

## ❖ Classification

- AWS/SFA 5.18 ER70S-6

## ❖ % Chemical Composition

| Type of Wire |     | C    | Mn   | S     | Si   | Mo   | P     | Ni   | Cr   | V    | Cu   |
|--------------|-----|------|------|-------|------|------|-------|------|------|------|------|
| ER70S-6      | Min | 0.06 | 1.40 | -     | 0.80 | -    | -     | -    | -    | -    | -    |
|              | Max | 0.15 | 1.85 | 0.035 | 1.15 | 0.15 | 0.025 | 0.15 | 0.15 | 0.03 | 0.50 |

## ❖ Mechanical Properties of all weld metal

| Condition | UTS, MPa (Min) | YS, MPa (Min) | % Elongation | Charpy "v" Notch Impact @ -30°C |
|-----------|----------------|---------------|--------------|---------------------------------|
| As Welded | 490            | 400           | 22           | 27J                             |

## ❖ Wire Size & Welding Position

Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60

- Weld Position- All position

## ❖ Current & Gas Flow

- DCEP; 15-22lit/min

## ❖ Packaging

|                       |                                          |       |        |        |        |       |                 |                 |                 |  |
|-----------------------|------------------------------------------|-------|--------|--------|--------|-------|-----------------|-----------------|-----------------|--|
| Sizes Available in mm | 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60 |       |        |        |        |       |                 |                 |                 |  |
| Packing Code          | A                                        | B     | C      | D      | E      | F     | G               | H               | I               |  |
| Packing Available     | SD 100                                   | SD200 | SD270  | SD 270 | SD300  | SD300 | 100kg Drum Pack | 250kg Drum Pack | 350kg Drum Pack |  |
| Net Weight of Wire    | 1KG                                      | 2KG   | 12.5KG | 15KG   | 12.5KG | 15KG  | 100KG           | 250KG           | 350KG           |  |

### Special Notes: -

- All the value above mentioned are typical values.
- Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

## SHAKUNT ENTERPRISES PRIVATE LIMITED

**Corporate Office:** - 619/A, EMMAR DIGITAL GREEN, 6th Floor, Sector-61, GURUGRAM (HARYANA)-122102  
E-Mail:- [info@shakunt.com](mailto:info@shakunt.com)

**Ludhiana Works:-** B-XXIX-595/5, Campa Cola Road, Dhandari Kalan Industrial Area-C, Ludhiana (PUNJAB) [INDIA](#)

**Dharwad Works:-** Plot no.577 C & D, Belur Industrial Area, Dharwad-580011 (KARNATAKA) [INDIA](#)

**Vadodara Works:-** 67-A, G.I.D.C, Majusar, Savli, Vadodara-397115 (GUJARAT) [INDIA](#)