

❖ Product Description

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| I. A copper coated wire | IV. Smooth feedability and low spatter occurrence |
| II. Best suitable for general welding | V. Radiographic weld quality |
| III. Good uniform weld beads | |

❖ Range of Application

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| 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	Charphy "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: -

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

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