

❖ Product Description

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| I. Premium quality high speed copper coated wire with tensile strength up to 510MPa | IV. Minimum spatter occurrence when under optimum conditions |
| II. Uniform copper coating for smooth feedability | V. The weld deposit is free from porosities with very smooth and uniform weld bead |
| III. Extremely suitable for single pass or multi pass welding | |

❖ Range of Application

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|---|--|
| I. Extremely suitable for welding of structural steel | III. Good for fillet and butt weld in automobile industry |
| II. Wide usage in heavy automobile machines | IV. Can be used in almost any industrial segment for general fabrication |

❖ Classification

- AWS/SFA 5.18 ER70S-2

❖ Chemical Composition

Type of Wire		C	Mn	S	Si	P	Cu	Mo	V	Ni	Ti	Zr	Al
ER70S-2	Min	-	0.90	-	0.40	-	-	-	-	-	0.05	0.02	0.05
	Max	0.07	1.40	0.035	0.70	0.025	0.50	0.15	0.03	0.50	0.15	0.12	0.15

❖ 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 & Weld Position

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

❖ Current and Gas- Flow Rate

- DCEP & 15-22 lit/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 Note: -

All the value above mentioned are typical values.

- (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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