

## ❖ Product Description

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|---|--|
| I. The silicon and manganese content are kept moderate for deoxidization of clean to light mill scale surface | III. Copper coating for long contact tip life  |
| II. Smooth wire feeding and stability of arc  | IV. All modes of metal transfer i.e. short circuiting, globular, axial spray and pulsed spray transfer are supported without any hazel |

## ❖ Range of Application

- |  |  |
|--|--|
| I. Suitable for pipeline fabrication works   | IV. Good for fillet and butt weld in automobile industry |
| II. Pressure vessels                         |  |
| III. Wide usage in heavy automobile machines |  |

## ❖ Classification

- FABMIG AWS/SFA 5.18 ER70S-3

## ❖ Chemical Composition

Type of Wire		C	Mn	S	Si	P	Cu	Ni	Mo	V	Cr
ER70S-3	Min	0.06	0.90	-	0.45	-	-	-	-	-	-
	Max	0.15	1.4	0.035	0.75	0.025	0.50	0.15	0.15	0.03	0.15

## ❖ 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 and Welding 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.

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- Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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