

❖ Product Description

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|---|-------------------------------------|
| I. Copper coated low alloy wire | IV. High resistant to cold cracking |
| II. Smooth wire feeding and arc stability | V. Radiographic weld quality |
| III. Increase in strength at elevated temperature | |

❖ Range of Application

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| I. Welding creep resistant 0.5% Mo steels and fine grained steels with service temperature upto 500°C | IV. Suitable for pipe line and crane construction and structural engineering |
| II. For high temperature and pressure boilers | |
| III. For welding low alloy steels | |

❖ Classification

- AWS/SFA 5.28 ER70S-A1

❖ % Chemical Composition

Type of Wire		C	Mn	Si	P	S	Ni	Cu	Mo	Other Elements
ER70S-A1	Min	-	-	0.30	-	-	-	-	0.40	-
	Max	0.12	1.30	0.70	0.025	0.025	0.20	0.35	0.65	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charphy "v" Notch Impact @ 0°C
PWHT	515	400	19	-

❖ 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

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