

❖ Product Description

- | | |
|--|--|
| <ul style="list-style-type: none"> I. Deoxidisers Si-Mn are added for improved performance II. Welding is stable and uniform III. The weld beads formed are uniform due to stable arc | <ul style="list-style-type: none"> IV. The weld produced is of Radiography Quality V. Spatter occurrence minimizes with optimum welding conditions |
|--|--|

❖ Range of Application

- | | |
|---|--|
| <ul style="list-style-type: none"> I. Can be used for repairing different mild and low alloy steel II. Can be used in thin sheet metal and automotive parts | <ul style="list-style-type: none"> III. Effective application in high pressure piping in ship building, nuclear power plant and also in petro chemical industry IV. Can be used in welding in agricultural equipment V. In pressure vessels |
|---|--|

❖ Classification

- AWS/SFA 5.18 ER70S-3

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Cu	Cr	Mo	V	Ni
ER70S-3	Min	0.06	0.90	-	0.45	-	-	-	-	-	-
	Max	0.15	1.40	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 & Weld Position

- Diameter in mm-1.6, 2.0, 2.40, 3.20, 4.00 and 5.00.
- All position

❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

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.

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**