

❖ Product Description

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| <ul style="list-style-type: none"> i. Greater strength and improved performance than traditional ER70S-6 products ii. Improved and better wetting action iii. Copper coating is uniform | <ul style="list-style-type: none"> iv. The entire electrode is printed with inkjet print for good identification v. Good quality of weld pool flow which results in good uniform weld beads vi. The weld produced is of Radiography Quality |
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❖ Range of Application

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| <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 |
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❖ Classification

- AWS/SFA 5.18 ER70S-6

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Cu	Ni	Cr	Mo	V
ER70S-6	Min	0.06	1.40	-	0.80	-	-	-	-	-	-
	Max	0.15	1.85	0.035	1.15	0.025	0.50	0.15	0.15	0.15	0.03

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation min	Charpy "v" Notch Impact @ -30°C
As Welded	490	400	22	27J

❖ Wire Sizes & 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.

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