

ER70S-6

FWELDING WIRE

AWS A5.18 ER70S-6

DESCRIPTION

Welding wire **ER70S-6** is a type of shielded gas welding, suitable for welding all carbon steel and low alloy steel. Shielded gas can be 100% of Co₂. Welding process generates stable arc, less spatter, high welding effectiveness and less air hole. It can be welded in all positions with high current.

ER70S-6 has tensile strength around 540MPa. It can be used to weld engine structures, bridges, constructions, mechanics. It also can be used for thin plate, pipe welding at hi-speed.

DIA (mm):

φ0.9 / φ1.2

CURRENT (A):

80 – 250 / 120 – 350

VOLTAGE (V):

21 – 23 / 23 – 25

GAS FLOW (L/min):

9 – 11 / 12 – 14

APPROVALS:

GL 3YH10S
 LR 3YS
 BV SA3YH10
 ABS 4YSAH10
 KR 3YSG(C1)
 NKK KSW54G(C)

	Chemical Composition				
	% C	% Mn	% Si	% S	% P
ER70S-6	0.08	1.40	0.80	0.015	0.018

	Mechanical Property				
	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact value (J/00C)	Shield gas
ER70S-6	450	540	30	100	100% CO ₂

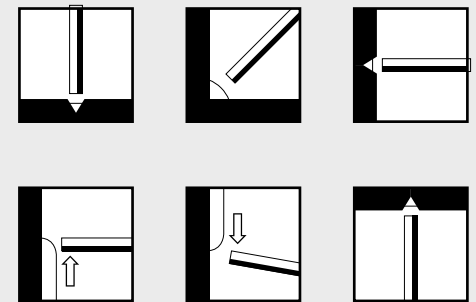
APPLICATIONS

- Steel Buildings.
- Ship and hydropower plants.
- Structure of bridges, pressure vessels, buildings and tanks.

FEATURES

- Stable arc, less spatter, less smoke than bare welding wire.
- Tensile strength as well as higher welding performance.
- Better quality weld surface than bare welding wire.

WELDING POSITIONS



SHIELDING GAS

- 100% CO₂

DIAMETERS

- 0.045" (1.2mm)
- 0.035" (0.9mm)