

ER70S-6 MIG GAS-SHIELD WELDING WIRE

Standard: AWS A5.18 ER70S-6 GB/T8110 ER50-6 JIS Z3312 YGW-12

Description: Suitable for all-position welding; applicable to wide current range; Stable electric arc under the Operating condition of low current; few spark spatters; widely applied to structure welding like but joint welding and fillet welding in the industries shipbuilding, bridge, architecture and machinery .

Chemical compositions of weld wire (wt%):(shielding gas:Co2)

C	Mn	Si	P	S
0.080	1.47	0.85	0.010	0.012

Mechanical Properties of Weld Pass:(Shielding gas:co2)

Tensile strength Mpa	Yield strength Mpa	Elongation %	Impact value -29°C J
510	580	31	96

Welding Parameter (DC+)

Wire Diameter(mm)		0.6	0.8	0.9	1.0	1.2	1.6	2.0
Current Range (Amp)	Flat position welding	80-180	80-220	80-220	100-250	140-350	200-400	200-500
	Overhead position welding	80-160	80-180	80-180	80-180	80-250	-	-
	Vertical up welding	50-120	50-140	50-140	50-150	50-160	-	-
	Vertical down welding	50-180	50-200	50-200	50-200	50-250	-	-

Package Size:

Diameter(mm)	0.6	0.8	0.9	1.0	1.2	1.6	2.0
Weight(kgs)/spool	1/5/15/20						
Diameter(mm)/spool	1kg/D100, 5kgs/D200, 15kgs/D270, 15kgs/D300, 20kgs/D270						

Drum Package:

Dire diameter(mm)	0.6	0.8	0.9	1.0	1.2	1.6	2.0
Weight(kgs)/Drum	100/150/250/350						

