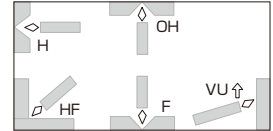


Solid wire**Classification:** ASME / AWS A5.18 ER70S-6

Features:

- Higher currents can be applied in vertical and overhead positions
- Suitable for pipe welding in all positions

Shielding gas: CO₂**Polarity:** DC-EP**Welding Positions:****Chemical composition of wire (%) as per AWS (Shielding gas: CO₂)**

	C	Si	Mn	P	S	Cu
Example	0.10	0.88	1.56	0.011	0.012	0.24
Guaranty	0.06~ 0.15	0.80~ 1.10	1.40~ 1.85	≤0.025	≤0.030	≤0.50

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	Shielding gas
Example	470	560	32	-29°C: 70	CO ₂
	520	600	31	-29°C: 90	80%Ar-20%CO ₂
Guaranty	≥400	≥480	≥22	-29°C ≥27	CO ₂

Recommended welding parameters

	0.9mm	1.0mm	1.2mm
F, HF	50~200A	50~220A	80~350A
H	50~180A	50~200A	80~300A
VU	50~140A	50~140A	50~160A
OH	50~120A	50~120A	50~140A

Packages

Dia. (mm)	Type	Weight (kg)	Dia. (mm)	Type	Weight (kg)
0.9	Spool	20	1.2	Spool	20
1.0	Spool	20		Pack	300
	Pack	250			