



# AUTOMIG 70S-6N

GMAW C-Mn Steel

AWS A/SFA 5.18 **ER70S-6**

### CLASSIFICATION:

EN ISO 14341-A

G 46 4 M21 3Si1

G 46 4 M24 3Si1

IS 6419

S4-C/M 504

### KEY FEATURES:

- Copper free C-Mn steel solid wire
- Smooth and stable arc
- Lowest spatter, Smooth feedability
- Best anti-rust properties
- Low smoke levels
- Best suited for high speed welding
- Operates at high current density
- Suitable for applications where dirt, rust or mill-scale is present
- Radiographic quality weld

**APPROVALS:** CWB/CE

### TYPICAL APPLICATIONS:

- Construction and mining equipment
- Structural steel components
- Frame fabrication, Tanks
- General fabrication
- Auto body
- Farm implements, Steel casings
- High-speed robotic, automatic and semiautomatic welding applications

### TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:


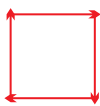
C	Mn	Si
0.075	1.45	0.85

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -40°C, J
Typical	As Welded	590	480	26	50

Hardness, 3 Layer: 200 BHN max

### PARAMETERS - PACKING DATA:

Ø, mm	Wt / Spool, kg		All Positions
0.8	15	 <b>DCEP</b> <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	
1.0	15		
1.2	15		
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
80Ar+20CO <sub>2</sub>	17-22