

ER70S-6 MIG WELDING WIRE 气保焊丝

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 butt joint welding and fillet welding in the industries of shipbuilding, bridge, architecture and machinery.

An example of chemical Compositions of Weld wire(wt%):(Shielding gas:CO2)

C	Mn	Si	P	S
0.080	1.47	0.85	0.010	0.012

An example of mechanical Properties of Weld Pass:(Shielding gas:CO2)

Yield Strength Mpa	Tensile Strength Mpa	Elongation %	Impact Value -29°C J
510	580	31	96

Welding Parameter Suggestions: (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	200-40	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:

Wire Diameter(mm)	0.6	0.8	0.9	1.0	1.2	1.6	2.0
Weight(kg)/spool	0.9/5.0	0.9/5.0/15.0		15.0			
Diameter(mm)/spool	0.9kgs/D100, 5kgs/D200, 15kgs/D270, 15kgs/D300						