

AWS A5.18/ASME SFA5.18 ER70S-6

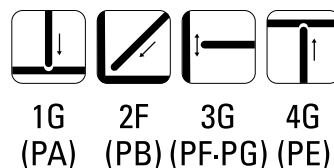
Applications

- General fabrication
- Steel Industry
- Automotive

Features

- All position welding by short-circuiting type transfer
- Stable arc and low spatter
- Good bead appearance
- Cooper Coated Mild Steel Welding wire

Welding Position



Current

DC +

Shielding Gas

100% CO₂
Ar + 20~25% CO₂

Typical Chemical Composition of the Wire(%)

C	Si	Mn	P	S
0.07	0.83	1.48	0.011	0.015

Typical Mechanical Properties of All-Weld Metal

	YS Mpa(lbs/in ²)	TS Mpa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.lbs)
As welded with 100% CO ₂	460 (67,000)	555 (80,000)	29.3	-29 (-20)	85 (63)
As welded with 80% Ar + CO ₂	495 (72,000)	585 (85,000)	27.5	-29 (-20)	113 (83)
As welded with 90% Ar + CO ₂	495 (72,000)	590 (85,600)	26.4	-29 (-20)	101 (74)

Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	5kg (11lbs)	15kg (33lbs)	20kg (44lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
0.8 (0.033)	✓	✓	✓	✓	✓	✓
0.9 (0.035)	✓	✓	✓	✓	✓	✓
1.0 (0.040)	✓	✓	✓	✓	✓	✓
1.2 (0.045)	✓	✓	✓	✓	✓	✓
1.4 (0.052)	✓	✓	✓	✓	✓	✓
1.6 (1/16)	✓	✓	✓	✓	✓	✓