



FOR CARBON STEEL
PRODUCT (GMAW)
ER70S-6

FEATURES

- *ALL POSITION WELDING BY SHORT-CIRCUITING TYPE TRANSFER
- *MIXED GAS
- *GOOD BEAD APPEARANCE AND LOW SPATTER

APPLICATION

STRUCTURAL FABRICATION, AUTOMOTIVE, MACHINERY

CLASSIFICATION

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

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.08	0.95	1.7	0.012	0.015	0	0	0

MECHANICAL PROPERTIES

Y.S 100% CO2	T.S 100% CO2	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2)	N/mm2 (lbs/in 2)	(%)	oC (oF)	J (ft lbs)
460 (67,000)	555 (80,000)	27	-29 (-20)	85(63)

WELDING PARAMETERS

DIAMETER (mm)	0.8	1.2
SPOOL (KGS)	15	15
CURRENT (amps)		

CURRENT

DC +

GAS

100% CO2

Ar + CO2

WELDING POSITIONS

Current

= + ~ (U_o: 50 V)



ASME:	1G	2F	2G	3G	3G	4G	5G
ISO 6947	PA	PB	PC	PF	PG	PE	PF/PG
