

70S6

MICRO WIRE TYPE SOLID ELECTRODE WITH THIN COPPER COATING. IT IS USED WITH LOW CARBON STEEL IN ALL WELDING POSITIONS.

CLASSIFICATION A.W.S: ER-70S-6

APPLICATIONS: Microwire is used in the railway, marine, oil, petrochemical and automotive industries. It is also used in the manufacture of metal furniture, in the construction of bridges, towers, tanks, boilers, pipes, frames, piers, etc.

CHARACTERISTICS AND PROCEDURE: Microwire is used in the semi automated (GMAW) process or in M.I.G.process where CO₂, Argon-CO₂ and Argon-O₂ mixtures are used as shielding gas. This welding rod can be efficiently used with short arc or "Spray" type arc to produce a dense, mild, pore free weld of excellent appearance and mechanical properties.

PROCEDURE: Use reverse polarity DC. Filler metal transfer is achieved through repeated short circuits--"Spray" type--to produce an excellent looking weld which is free from defects and highly reliable for X-ray testing.

TENSILE RESISTANCE:	6,045 KG./CM ² (86,000 PSI)
ELASTIC LIMIT:	4,780 KG./CM ² (68,000 PSI)
ELONGATION IN 5 cm:	26%
BRINELL HARDNESS:	160 - 180
CURRENT:	DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Mn	P	S	Si	0.89 mm - 0.035"	90-160
0.10	1.62	0.013	0.019	0.98	1.14 mm - 0.045"	180-220