

AUTOCRAFT LW1-6



- ▲ A Higher Manganese / Silicon Wire for GMAW Welding of Mild & Low
- ▲ Designed for Use with CO₂ and Argon Based Shielding Gases.
- ▲ Wide Range of Minispool, Handispool and Autopak Packaging Options.

Classifications:

AS/NZS 2717.1: (old) ES6-GC/M-W503AH.
 AS/NZS 14341: (new) B G 49A 3U C1/M21/M24 S6
 AWS/ASME-SFA A5.18: ER70S-6.

Description and Applications:

Autocraft LW1-6 is a high quality copper coated welding wire suitable for the all positional Gas Metal Arc Welding (GMAW) of mild and low alloy steels, used in general fabrication and structural work. The high quality copper coating ensures problem free feeding, smooth current pick-up and minimal contact tip wear. The higher silicon content of Autocraft LW1-6 ensures excellent operator appeal, improved fillet shape / side wall wash at weld toes and very low spatter levels important for welding light to medium gauge sheet and tubular steel sections. Fillet welds exhibit a mitre to slightly convex profile with an even and smooth contour. The higher Manganese / Silicon levels give improved weld metal deoxidation when welding steels with moderate amounts of rust or mill scale.

Storage Recommendations:

When held under the recommended storage conditions unopened packs of Autocraft LW1-6 wires are expected to remain in 'factory fresh' condition for at least 12 months.

For storage over 12 months or under adverse (damp or high humidity) climatic conditions the use of heated weather proof store rooms/cupboards/containers maintained at 10-15°C above ambient temperature (with a maximum of 40°C) and at a maximum humidity of 60% R.H. is recommended. Product should be stacked on racks or pallets clear of the floor and walls.

TYPICAL WIRE ANALYSIS:

C: 0.07%	Mn: 1.55%	
S: 0.012%	P: 0.015%	Si: 0.88%

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

1.0 - 2.0 mls of hydrogen / 100gms of deposited weld metal.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

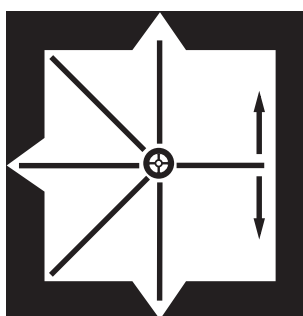
	Argon + 18-25% CO ₂	Welding Grade CO ₂ :
Yield Stress	460 MPa	425 MPa
Tensile Strength	550 MPa	525 MPa
Elongation	29%	32%
CVN Impact Val.	120 J @ -20°C	110 J @ -20°C

RECOMMENDED* SHIELDING GAS:

AS 4882:	ISO 14175 / AWS A5.32:
SG-AC-8, or SG-AC-10	M20
SG-AC-18, or SG-AC-20	M21*- Cert supplied
SG-ACO-5/2	M23
SG-C	C1
Ar+CO ₂ (8-25%) or Ar+CO ₂ +O ₂ or Welding Grade CO ₂	

COMPARABLE CIGWELD PRODUCTS:

Comweld LW1-6 TIG rod:
 AWS/ASME-SFA A5.18: ER70S-6



All positional welding applications

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Packaging and Operating Data:

Wire Diameter mm	Voltage Range (volts)	Wire Feed Speed (meters/min)	Current Range (amps)	Pack Type*	Pack Weight	Part No
0.8	14-22	3.5-14	50-180	Handi Spool	5kg	721109
				Spool	15kg	720114
0.9	15-26	3.5-15	70-230	Handispool	5kg	720161
				Spool	15kg	720090
				AutoPak	250kg	720122S
1.0	16-29	3.5-15	100-280	Spool	15kg	720094
				AutoPak	250kg	720123S
1.2	18-32	2.5-15	120-350	Spool	15kg	720096
				AutoPak	250kg	720124S
1.6	18-34	2.5-10	180-390	Spool	15kg	720095
				**AutoPak	350kg	720125S

* Mini Spool (ø100mm); Handi Spool (ø200mm); Spool (ø300mm); AutoPak (ø510mm x H.770mm);** AutoPak (ø650mm x H820mm).

AUTOPAK® Parts List:
AUTOPAK accessories "Standard Types".

1. Clear plasti AUTOPAK dome (510mm base diam. x 300mm height).

2. AUTOPAK conduit assembly kit

3. AUTOPAK robot cell kit

Part Number.

720001

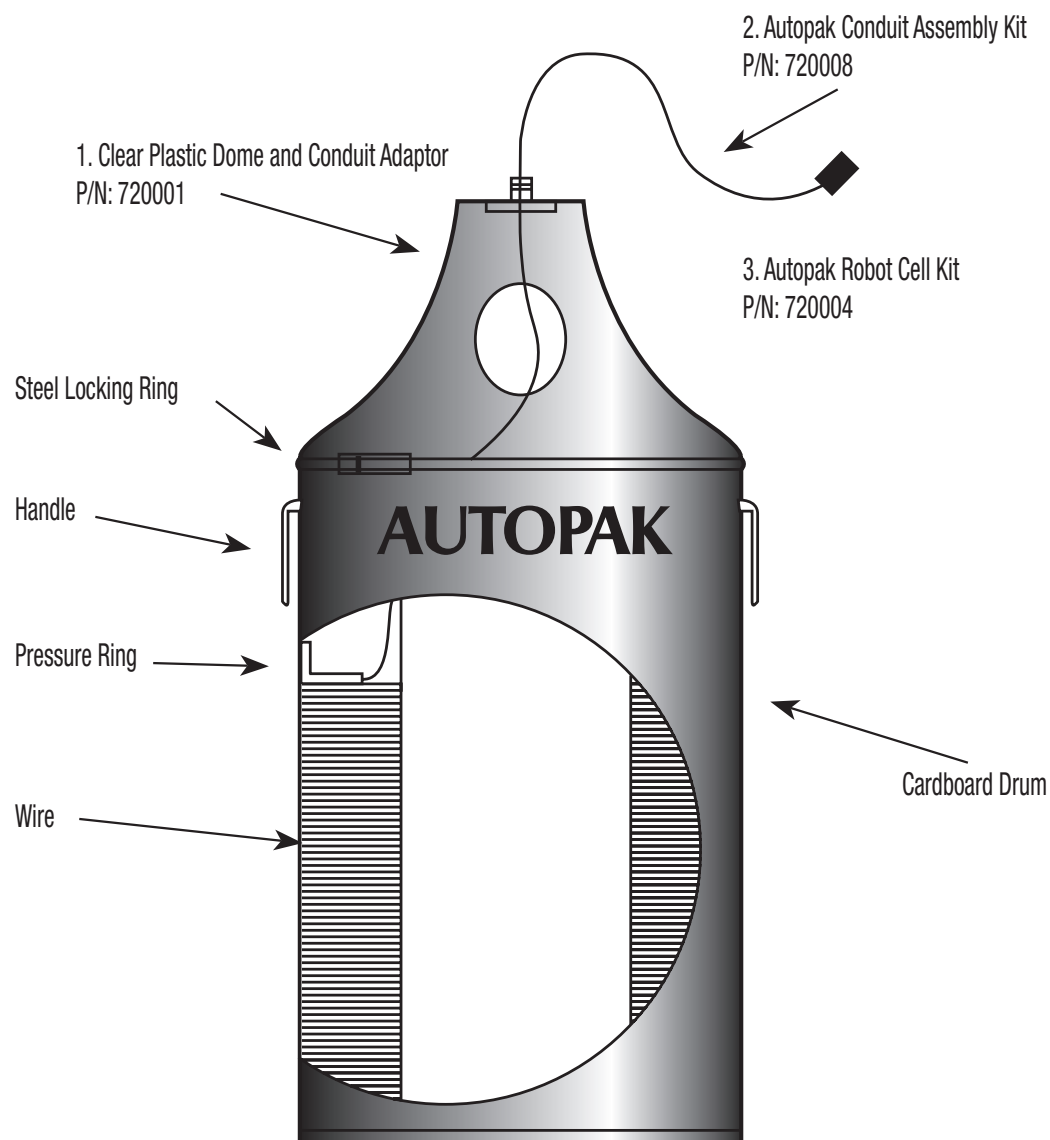
720008

720004*

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The advantages of AUTOPAK®.



- ◆ Reduced downtime
 - ◆ Straight/Twist free wire
 - ◆ Smaller Acceleration weight
 - ◆ Fully Enclosed pack and pay-off system
 - ◆ Compact and manoeuvrable
- = Higher productivity outcomes.
 - = Greater wire accuracy in the joint.
 - = Improved arc starting.
 - = Less stress on wire-feed unit.
 - = Less wire slippage and burn backs.
 - = Protection against dust, dirt and moisture.
 - = Ease of use in confined and restricted locations.
- Autopak occupies only 0.2m² of floor space.