



Product Data Sheet

G 'Gas-shielded metal-arc welding'

Weld 70S-6

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
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REASON FOR ISSUE

Approvals amended

GENERAL

A copper coated, ER 70S-6 solid wire for GMAW of all general structural and engineering unalloyed and low-alloyed carbon-manganese steels. The electrode may be welded with either a gas mixture or with pure CO₂ as the shielding gas.

Shielding Gas: M21, C1 (EN ISO 14175)

CLASSIFICATIONS Weld Metal

EN ISO 14341-A G 38 2 C1 Z 3Si1

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.18 ER70S-6

CHEMICAL COMPOSITION

All Weld Metal (%) Wire/Strip (%)

	CO ₂ (C1)		
	Nom	Min	Max
C	0.07	0.06	0.12
Si	0.9	0.80	1.15
Mn	1.5	1.40	1.80
P	0.013		0.025
S	0.010		0.025

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Standard	Shielding Gas	Condition	Rp0.2 [MPa/ksi]		Rm [MPa/ksi]			A4 [%]	
			Min	Typ	Min	Max	Typ	Min	Typ
AWS	CO ₂	As welded	400/58		480/70			22	

Comments:

Standard	Shielding Gas	Condition	Temp [°C/°F]	Charpy V [J/ft-lb]	
				Min	Typ
AWS	CO ₂	As welded	-29/-20	27/20	

Comments:

Part No	Description	Diameter	Weight	UOM	Pallet Weight
321M06460M	Weld 70S-6	0.6mm	5kg	RL	800kg
321M08460M	Weld 70S-6	0.8mm	5kg	RL	800kg
321M09460M	Weld 70S-6	0.9mm	5kg	RL	800kg
321M08540M	Weld 70S-6	0.8mm	15kg	RL	900kg
321M09540M	Weld 70S-6	0.9mm	15kg	RL	900kg
321M10540M	Weld 70S-6	1.0mm	15kg	RL	900kg
321M12540M	Weld 70S-6	1.2mm	15kg	RL	900kg
321M16540M	Weld 70S-6	1.6mm	15kg	RL	900kg
321M09592M	Weld 70S-6	0.9mm	250kg	Drum	1000kg
321M10592M	Weld 70S-6	1.0mm	250kg	Drum	1000kg
321M12592M	Weld 70S-6	1.6mm	250kg	Drum	1000kg