

WELD 70S-6

ESAB Weld 70S-6 is a copper-coated AWS ER70S-6 solid wire, suited for general purpose, manual and semiautomatic applications in most industries. It is manufactured under ESAB's Quality Control programs and meets AWS standards.

Classifications Weld Metal	EN ISO 14341-A : G 38 2 C1 Z 3Si1
Classifications Wire Electrode	SFA/AWS A5.18 : ER70S-6 JIS : YGW 12
Approvals	ABS 3YSA (M21 & C1) CWB CSA W48-18 JIS YGW12 LR 3Y H15 (M21 & C1)
Industry	Automotive Civil Construction Industrial and General Fabrication Mobile Equipment Ship/Barge Building

Approvals are based on factory location. Please contact ESAB for more information.

Shielding Gas	M21, C1 (EN ISO 14175)
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Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.07	1.5	0.9	0.010	0.013

Deposition Data

Diameter	Optimal Amps	Current	Voltage	Wire Feed Speed	Electrode Unit
0.9 mm (.035 in.)	200 A	180-230 A	25-27 V	1016-1397 cm/min (400-550 in./min)	206 m/kg (3670 in./lb)
0.9 mm (.035 in.)	130 A	90-160 A	15-19 V	457-762 cm/min (180-300 in./min)	206 m/kg (3670 in./lb)
1.2 mm (.045 in.)	160 A	130-200 A	17-19 V	318-508 cm/min (125-200 in./min)	124 m/kg (2220 in./lb)
1.2 mm (.045 in.)	300 A	260-340 A	25-30 V	762-1270 cm/min (300-500 in./min)	124 m/kg (2220 in./lb)