

ER70S6



Specifications / Certifications:

- AWS A5.18
- ASME SFA A5.18
- CWB Approved
- ABS Approved
- DNV Approved
- TUV Approved

Features

- Good tolerance to rust, scale, and other plate contaminants.
- Reduced flaking.
- Improved weld performance.

Applications

- Suitable for welding steels with moderate amounts of scale or rust.
- Single to multi pass welding
- MIG Metal Inert Gas and MAG Metal Active Gas
- Farm Equipment
- Gate Manufacturers
- Plant Shut Downs
- Utility Plant General Fabrication
- Shipbuilding
- Car Hauling Trailers
- Utility Trailers
- Pipe Fabrication
- Automotive Structures
- Construction Equipment
- Heavy-duty Welding/Structural Steel

Technical Specifications

Recommended Weld Parameters:

Short Arc Welding				
Diameter	Volts	Amps	IPM	Shielding Gas
0.030	16-18	75-125	176-324	100% CO ₂
0.035	15-18	100-160	132-228	100% CO ₂
0.045	17-18	100-220	149-208	100% CO ₂
Spray Arc Welding				
Diameter	Volts	Amps	IPM	Shielding Gas
0.030	26-28	200	560	90% Argon / 10% CO ₂
0.035	27-29	250	504	90% Argon / 10% CO ₂
0.045	28-31	265	336	90% Argon / 10% CO ₂
0.052	29-31	300-340	280-350	90% Argon / 10% CO ₂
1/16	30-36	350-400	220-280	90% Argon / 10% CO ₂

Typical Chemical Composition:

Chemical	C	Mn	Si	P	S
	0.06-0.15	1.40-1.85	0.80-1.15	0.025 max	0.035 max
Chemical	Ni	Cr	Mo	V	Cu
	0.15 max	0.15 max	0.15 max	0.03 max	0.50 max

Typical Mechanical Properties:

Tensile Strength	Yield Strength	Percent Elongation	CVN Impact at 20°F
70,000 psi min	58,000 psi min	22% min	20 ft/lbf min

Shielding Gas: 100% CO₂, 75-95% Ar/balance CO₂, 95-98% Ar/balance O₂, 100% Ar, 30-50 cfm

Diameters & Packages

Diameter		Lbs	Pkg	Pkg Dimensions (in)	Pallet Pkg Qty	Lbs per Pallet
0.023"	23/1000"	2	Spool	4.5 x 4.5 x 2.5		
		11	Spool	8.5 x 8.5 x 2.5		
		33	Spool	12 x 12 x 4	72 Spools/Pallet	2376
0.030"	1/32"	2	Spool	4.5 x 4.5 x 2.5		
		11	Spool	8.5 x 8.5 x 2.5		
		33	Spool	12 x 12 x 4	72 Spools/Pallet	2376
		44	Spool	12 x 12 x 4	60 Spools/Pallet	2640
		550	Drum	22 x 22 x 32	4 Drums/Pallet	2200
0.035"	7/200"	2	Spool	4.5 x 4.5 x 2.5		
		10	Box	37.5 x 2 x 2		
		11	Spool	8.5 x 8.5 x 2.5		
		33	Spool	12 x 12 x 4	72 Spools/Pallet	2376
		44	Spool	12 x 12 x 4	60 Spools/Pallet	2640
		500	Drum		4 Drums/Pallet	2000
		550	Drum	22 x 22 x 32	4 Drums/Pallet	2200
		880	Drum	27 x 27 x 32	2 Drums/Pallet	1760
0.045"	3/64"	1000	Drum	27 x 27 x 32	2 Drums/Pallet	2000
		2	Spool	4.5 x 4.5 x 2.5		
		10	Box	37.5 x 2 x 2		
		11	Spool	8.5 x 8.5 x 2.5		
		33	Spool	12 x 12 x 4	72 Spools/Pallet	2376
		44	Spool	12 x 12 x 4	60 Spools/Pallet	2640
		60	Coil			
		550	Drum	22 x 22 x 32	4 Drums/Pallet	2200
		880	Drum		2 Drums/Pallet	1760
0.052"	1/20"	1000	Drum	27 x 27 x 32	2 Drums/Pallet	2000
		44	Spool	12 x 12 x 4	60 Spools/Pallet	2640
		550	Drum	22 x 22 x 32	4 Drums/Pallet	2200
0.062"	1/16"	10	Box	37.5 x 2 x 2		
		33	Spool	12 x 12 x 4	72 Spools/Pallet	2376
		44	Spool	12 x 12 x 4	60 Spools/Pallet	2640
0.093"	3/32"	10	Box	37.5 x 2 x 2		
0.125"	1/8"	10	Box	37.5 x 2 x 2		
0.156"	5/32"	10	Box	37.5 x 2 x 2		
0.187"	3/16"	10	Box	37.5 x 2 x 2		