



# E70C-6M H4 BAKED

**Gas Shielded Carbon Steel  
Tubular Welding Wire**  
AWS A5.18

## Features

- Achieve high deposition rates and efficiencies, with hardly any slag
- Exceptional high-production performance with smooth arc characteristics
- Low levels of smoke and spatter produced due to the low diffusible hydrogen

## Applications

- Well-suited for welding steels that have moderate amounts of rust or scale
- It can be used for single and multi-pass welding, as well as automatic and mechanized welding. It is particularly effective for welding non-alloyed fine grain steels, storage vessels, steel structures, and rail cars

## Diameters & Packages

Diameter	33 lb	44 lb	60 lb	550 lb
0.045	✓	✓		✓
0.062	✓	✓		✓
0.093			✓	

## Technical Specifications

### Typical Chemical Composition:

Elements	75% Ar/25% CO2	90% Ar/10% CO2	AWS A5.18 Spec
Carbon (C)	.04	.04	.12 max
Manganese (Mn)	1.41	1.46	1.75 max
Silicon (Si)	.50	.51	.9 max
Sulphur (S)	.009	.010	.03 max
Phosphorus (P)	.006	.008	.03 max
Copper (Cu)	.01	.01	.5 max
Nickel (Ni)	.33	.32	.5 max
Chromium (Cr)	.02	.02	.2 max
Molybdenum (Mo)	.01	.01	.3 max
Vanadium (V)	.002	.002	.08 max

### Mechanical Properties

Hydrogen Test	1.52 ml /100g	1.56 ml /100g	4.0 ml /100g max
Tensile Strength	589 MPa	603 MPa	490 MPa min.
Yield Strength	523 MPa	556 MPa	400 MPa min.
% Elongation	28%	28%	22% min.
Impact value at -22 deg F (-30 deg C)	88	95	27J Min.

### Recommended Weld Parameters:

Diameter	Volts	Amps	Feed (in/min)
0.035	25-30	150-300	490-780
0.045	24-34	200-400	240-725
0.052	24-33	200-400	190-540
1/16	24-33	250-500	160-500
5/64	26-31	300-500	135-290
3/32	27-32	350-550	105-220