

WELDSKILL SOLID WELDING WIRE

PRODUCT DATA SHEET



COPPER COATED STEEL WIRE FOR GMA WELDING



WELDSKILL WELDING ELECTRODES & WELDING WIRES

WELDSKILL SOLID WELDING WIRE

- Copper coated steel wire for GMA welding.
- Use with CO₂ and Argon based shielding gases.
- Range of minispool and handispool packaging options.
- Suitable for the positional Gas Metal Arc Welding (GMAW) of mild and low alloy steels, used in general fabrication and structural work.

CLASSIFICATIONS:

ISO AS/NZS 2717.1:	ES6-GC/M-W503AH
AWS/ASME-SFA A5.18:	ER70S-6

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

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

TYPICAL MECHANICAL PROPERTIES:

	CO ₂ :	Argon + 18-25% CO ₂ :
Yield Stress	435 MPa	420 MPa
Tensile Strength	540 MPa	525 MPa
Elongation	30%	31%
CVN Impact Values	110 J @ -20°C	100 J @ -20°C

TYPICAL ALL WELD METAL ANALYSIS:

C:	0.08%
Mn:	1.45%
S:	0.010%
P:	0.015%
Si:	0.85%

RECOMMENDED* SHIELDING GAS:

ARGON + 10-15% CO ₂ (or equivalent)	ISO14175: M14, M21, M24
ARGON + 18-25% CO ₂ (or equivalent)	ISO14175: M21
ARGON + 5% CO ₂ + 3% O ₂	ISO14175: M23
Welding Grade CO ₂	ISO14175: C1

PACKAGING & OPERATING DATA:

WIRE DIAMETER (MM)	VOLTAGE RANGE (VOLTS)	WIRE FEED SPEED (METERS/MIN)	CURRENT RANGE (AMPS)	PACK TYPE*	PACK WEIGHT	PART NO.
0.6	12-14	3.5-14	35-100	Mini Spool	0.9kg	WS0906
				Handi Spool	5kg	WS5006
0.8	14-22	3.5-14	50-80	Mini Spool	0.9kg	WS0908
				Handi Spool	5kg	WS5008
0.9	14-26	3.5-15	70-230	Mini Spool	0.9kg	WS0909
				Handi Spool	5kg	WS5009

